

# Baking & Snack®

Baking & Snack is pleased to  
provide our latest digital magazine.

To access the Archives, Advertisers  
Index or a single page view,  
please refer to the toolbar above.

Click “Text View” to translate stories  
into more than 50 languages.

To receive each new digital edition  
[Click here to subscribe](#)

IN THIS ISSUE: PROTEIN • SNACK PROCESSING • OVENS

AUGUST 2023

[www.bakingbusiness.com](http://www.bakingbusiness.com)

# Baking & Snack®

A SOSLAND PUBLICATION

*The knowledge authority for development, production, packaging and distribution of grain-based foods.*

## BY POPULAR DEMAND

Dutchland Foods expands operations

Also inside:

Pizza  
Trends



100% SYNTHETIC  
HIGH-TEMPERATURE  
NSF H1 REGISTERED  
LUBRICANTS...

# MADE FOR THE BAKING INDUSTRY



Lubriplate's line of ultra high-performance, 100% Synthetic, NSF Registered Food Grade Lubricants includes products specifically engineered from the ground up to provide unsurpassed performance in processing equipment unique to the baking industry. They provide ultra high-temperature capability, extended lube intervals, multiple application capability and lubricant inventory consolidation, all while maintaining strict H1 safety requirements.

Available products include...

## HTCL-FG SERIES OVEN CHAIN LUBRICANTS

- High-performance, 100% synthetic, polyol ester (POE) formula.
- Eliminates carbon build-up - helps maintain clean chains.
- High auto-ignition temperatures reduces the risk of oven fires.
- Superior film strength reduces oil consumption and smoke.
- Free of harmful VOC's - creates a safer work environment.
- NSF H1 registered & NSF ISO 21469 certified food grade.
- Available in ISO grades 68 and 220.



## SYNXTREME HT MAX SERIES GREASES

- Advanced, high-performance, perfluoropolyether PFPE-based greases.
- Ultra high-temperature capability (Up to 550°F / 288°C).
- Provides long service life and extended lubrication intervals.
- Chemically inert - unaffected by strong acids and bases.
- Fortified with an anti-rust, anti-corrosion Inhibitor.
- NSF H1 registered & NSF ISO 21469 certified food grade.



Scan QR codes for additional product information



H1 REGISTERED



Certified Kosher Pareve



HALAL



ISO 21469 Certified



ISO 9001 Registered



**Lubriplate**  
H1 LUBRICANTS

Newark, NJ 07105 / Toledo, OH 43605 / 800-733-4755  
To learn more visit us at: [www.lubriplate.com](http://www.lubriplate.com)



INCLUDED AT NO ADDITIONAL CHARGE

**Lubriplate's  
ESP**

**Complimentary Extra Services Package**

COLOR CODED LUBE CHARTS & MACHINERY TAGS  
PLANT SURVEYS / TECH SUPPORT / TRAINING  
LUBRICATION SOFTWARE / FOLLOW-UP OIL ANALYSIS

# Baking & Snack

AUGUST 2023

www.bakingbusiness.com

A SOSLAND PUBLICATION

*The knowledge authority for development, production, packaging and distribution of grain-based foods.*

## SSV Series Drum Motor

The Most Hygienic Conveyor Belt Drive



Visit Us at Booth  
**#SU-8025**



Made In  
**USA**



Learn more:  
[www.vandergraaf.com/BK](http://www.vandergraaf.com/BK)  
(888) 326-1476





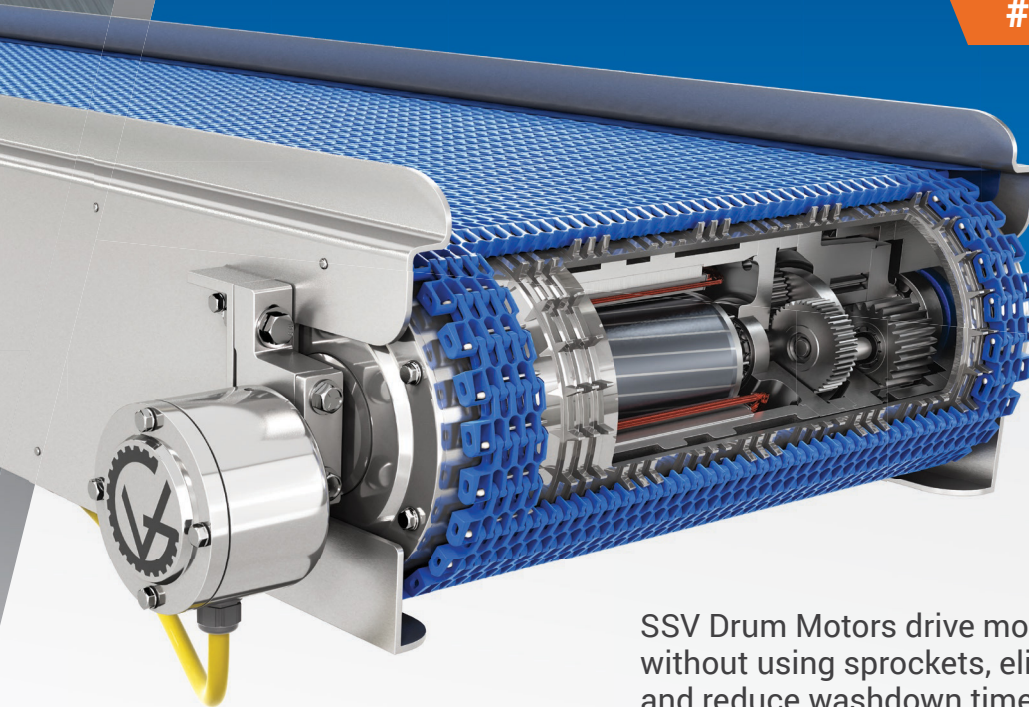
# SSV Series Drum Motor

The Most Hygienic Conveyor Belt Drive



Made In  
**USA**

Visit Us at Booth  
**#SU-8025**



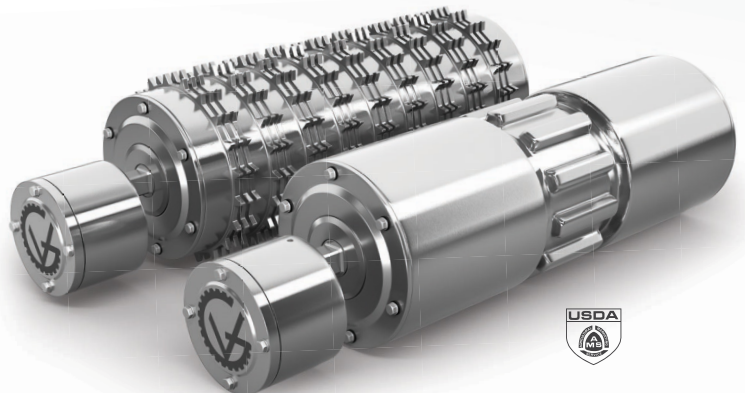
SSV Drum Motors drive modular conveyor belts without using sprockets, eliminate gaps and crevices, and reduce washdown time and water usage by 50%.

Designed for 80,000 hours of continuous operation before maintenance, SSV Drum Motors increase throughput and reduce operational costs.

- ▶ **Eliminate Drive Sprockets**
- ▶ **IP69K Sealing System**
- ▶ **Washdown Up to 3,000 psi**



Learn more:  
[www.vandergraaf.com/BK](http://www.vandergraaf.com/BK)  
(888) 326-1476



VALTARA™

# PKR-Delta

## Vision Guided Pick & Place Cell



### #ReadyToWork

- Up to 24 hours per day
- No vacations
- No workers comp
- No insurance
- No sick days
- No attitude

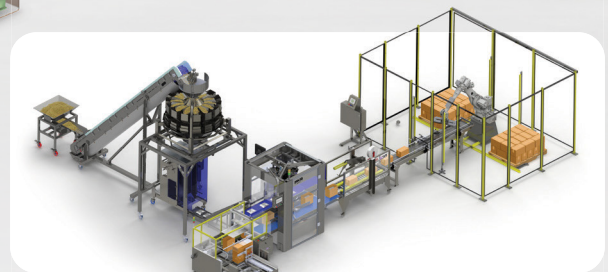
### Starting\* at:

\$14 per hour single shift

\$7 per hour double shift

\$4.66 per hour triple shift

*\*Investment adjusted to approximate hourly wage over 5 years*



Watch video at  
**paxiom.com**



Weighing



Pre-roll



Filling



Bagging



Wrapping



Capping



Sealing



Labeling



Cartoning



Forming



Packing



Palletizing

**WEIGHPACK**

**endflex**

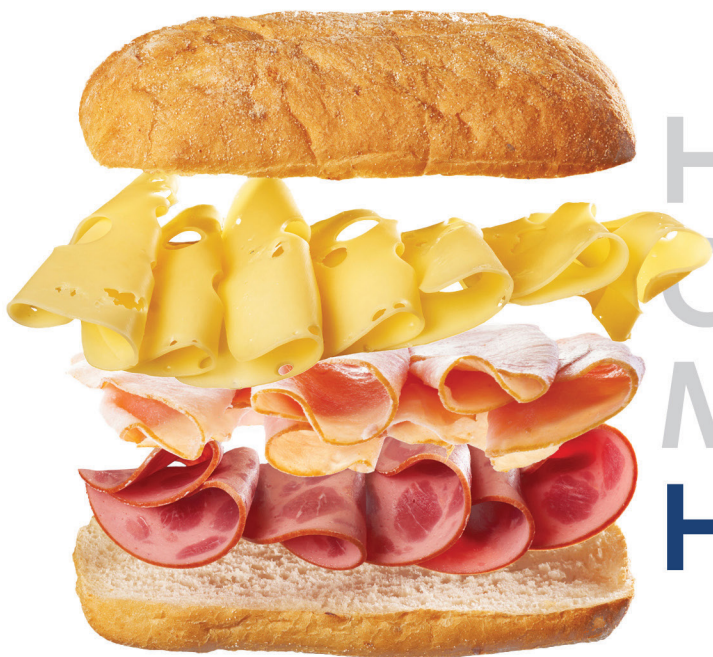
**VALTARA**

**CANAPA**

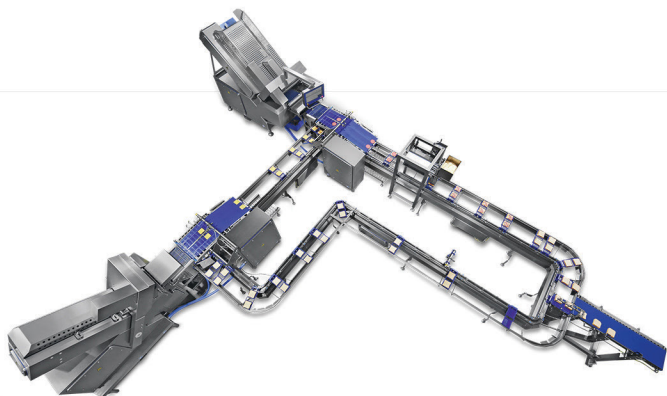
1.833.4PAXIOM PaxiomXperience PaxiomGroup

LAS VEGAS • MILWAUK EE • MIAMI • TORONTO • MONTREAL • SCHIO, ITALY





# HANDHELD CONVENIENCE MADE HANDS-FREE



As the labor market continues to present unprecedented challenges, traditional sandwich and convenience product assembly processes are becoming harder and harder to sustain. Give yourself the competitive advantage – leverage our hygienic slicing, and automation solutions to reduce the labor market impact on production. More throughput, higher efficiency. Weber's handheld convenience – created hands free.



COME SEE US AT:



Booth  
10815

ProcessExpo  
Booth 3748

[www.weberweb.com](http://www.weberweb.com)  
+1 (816) 891-0072

weber

# contents

14

August 2023 • Vol. 45, No. 7

## FEATURES

### 14 Big Expansion in a Small Town

Dutchland Foods adds space and automation as demand rises for its frozen pastries and other goodies.

### 28 Leaning Power of Pizza

Innovation in crusts, flatbreads and frozen dough fuels consumer purchases in the highly competitive pizza market.

### 40 A Natural Fit

Bakers win over increasingly health-conscious consumers with natural sweeteners.



28



40

Cover: At Dutchland Foods, which makes a wide variety of laminated pastries and other goodies, expansion is everywhere.

Photo: Dutchland Foods





## *Innovative Packaging Solutions for Bakeries* **Baggers, Wrappers, and Automated Systems**



**Induction heat technology that provides top quality seals while conserving energy is**  
*another advantage of doing business with*



Scan to Learn how to  
improve the eco-efficiency  
of your packaging line



**JOIN US AT PACK EXPO IN LAS VEGAS!**

Register for free using our comp  
code: 61B64

[www.formostfuji.com](http://www.formostfuji.com) 425-483-9090 [sales@formostfuji.com](mailto:sales@formostfuji.com)

***“Quality is: First and Formost”***

# contents

August 2023

Vol. 45, No. 7

## Trends

Pizza 28  
New Product Spotlight 114

## Formulation

Sweeteners 40  
Protein 51

## Equipment

Snack Processing 61  
Ovens 75  
Packaging Innovations 87

## Operations

Dutchland Foods 14

## Innovations

Featured Technical Expert Q&A 100  
Ingredients & Formulating 102  
Equipment & Packaging 104  
Patents 107  
New on the Shelf 108

## &

Editorial 8  
News 10  
Meeting Preview 97  
Calendar of Events 98  
Advertisers' Index 113



"We always had the thought that if we take care of our mistakes and treat our customers right, we'll turn them into a customer for life."

14

Pete Van Wyhe, Dutchland Foods





## Vying for protein

At IFT FIRST Annual Expo held last month in Chicago, plant-based protein was pervasive. As the industry deals with consumers' ongoing obsession with protein as a macro nutrient, this shouldn't really surprise. However, what did surprise me was the lack of conversation around fiber, the nutrient Americans are truly deficient in. The tension between protein and fiber illustrates the power consumers have over product development as well as the age-old story of consumers' wants not lining up with their needs.

The Dietary Guidelines for Americans, 2020-2025, reported that fewer than 10% of US adults are getting the daily recommended amount of dietary fiber. With that level of deficiency, I expected fiber to be a hot topic on the show floor as it has been in past years. However, bakers seem to be looking at fiber through a different lens — as a tool for sugar reduction — rather than an opportunity to fill a gap in the American diet. Fiber was present at IFT FIRST, for sure, but the nutritional boost these ingredients provide was less the focus and more its function as a bulking agent for reducing sugar in baked goods.

When it comes to health and nutrition, protein remains king. Even though the average American gets plenty of protein in their diet — largely without even trying — wellness culture has the public convinced that more protein is what

they need, whether for satiety or weight control/loss. Thanks to the many high-protein diets, protein has been the star for several years running, and plant-based protein even more so as consumers look for alternatives to animal protein, mostly for environmental or allergy reasons.

IFT FIRST saw the usual suspects: peas and other legumes, wheat, ancient grains, soy, and nuts and seeds. But chickpea seemed to be the star of the show with many suppliers showing its functional versatility and clean taste. Chickpea also benefits from familiarity that has been built with consumers over the years.

While chickpea may be having a moment, that doesn't mean the other sources of plant-based protein are out in the cold. As I heard from my conversations with ingredient suppliers, every bakery and snack application is different in its nutritional and functional needs. Every product will require a different taste profile, texture and have its own limitations in how much protein can be added. To get the most out of a protein boost without negatively impacting taste and texture, check out Donna Berry's feature "Packed With Protein" in this issue. You'll be able to learn the best practices and read all about the latest technology for protein, some of which I saw in Chicago. While consumers may need fiber, bakers and their R&D teams will always follow the money, and right now consumers are paying for protein.

— **Charlotte Atchley, Editor**  
[catchley@sosland.com](mailto:catchley@sosland.com)



### PUBLISHING STAFF

Group Publisher	Mike Gude
Publisher	James Boddicker
Media Sales Representative	Josh Buttshaw
National Account Executive	Tom Huppe
Inside Sales Specialist	Lauren Juliana
Senior Director of Marketing and Promotions	Kathi D. Gilleland
Sales Enablement Specialist	Whitney Hartman
Audience Development Manager	Dustin Pickman
Audience Database Specialist	Carlea Schuler
Director of Digital Media	Jon Hall
Digital Advertising Manager	Carrie Fluegge
Advertising Manager	Nora Wages
Advertising Coordinator	Kayley Kerns
Design Services Manager	Elisabeth Spillman
Production Specialist	Marj Potts
Senior Design Consultant	Becky White
Senior Graphic Designer	Brian Peterman
Promotions Manager	Jim White
Promotions Media Designer	Abby Chronister

### EDITORIAL

Editor	Charlotte Atchley
Executive Editor	Dan Malovany
Managing Editor	Keith Moore
Features Editor	Michelle Smith
Associate Editor	Lucas Cuni-Mertz
Digital Associate Editor	Taryn Parker
Contributing Editors:	Donna Berry Allison Gibeson

### CORPORATE

Chairman and CEO	Charles S. Sosland
President	L. Joshua Sosland
Chief Financial and Administrative Officer	Staci Greco
Chief Operating Officer and Executive Editor	Meyer Sosland

### Corporate Headquarters

4801 Main St., Suite 650, Kansas City, MO 64112  
Phone: (816) 756-1000; Fax: (816) 756-0494  
E-mail: [BakingSnack@sosland.com](mailto:BakingSnack@sosland.com)  
Internet: [www.bakingbusiness.com](http://www.bakingbusiness.com)

BAKING & SNACK is distributed free-of-charge to qualified readers with managerial responsibilities in the baking and snack food industries. SUBSCRIPTIONS: To apply, log on to [www.bakingbusiness.com](http://www.bakingbusiness.com) and select Magazine Subscriptions. For non-qualified readers, US and Canadian subscriptions are accepted at \$36 per year. Foreign subscriptions (from outside the territory of the US and its possessions and Canada) are accepted at \$72 per year. BAKING & SNACK assumes no responsibility for the validity of claims in items reported. ©2023 Sosland Publishing Company, a division of Sosland Companies, Inc. All rights reserved. Reproduction of the whole or any part of the contents without written permission is prohibited. Printed in USA

# YOUR SOLUTION PARTNER WITH LINE AND PROCESS EXPERTISE



LOOKING FORWARD  
TO GREAT CONVERSATIONS



ProcessExpo

**handtmann**

*Ideas for the future.*

[www.handtmann.us](http://www.handtmann.us) | [www.handtmann.ca](http://www.handtmann.ca)



## BBU exceeds diversity goals

Bimbo Bakeries USA (BBU), Horsham, Pa., published its annual Diversity, Equity and Belonging (DEB) report card to show the company's progress on commitments first introduced in 2022 that it pledged to reach by 2024. BBU has divided its DEB goals into three pillars: workforce, workplace and marketplace.

"The scorecard aims to show how we are staying focused on our diversity, equity and belonging goals and commitments and working to make authentic, meaningful progress in this space," the company said.

In the workforce category, the company reported it has reached 44% of its goal to achieve 48% diversity in gender and race at director and above levels. It has met its goal to ensure 50% diverse candidate slates, including at least 25% women and 25% racial-ly diverse.

In the workplace category, BBU has exceeded its goal to offer 45 hours of educational programming annually to salaried associates in the form of events, celebrations, forums and more. The company aims to engage all hourly and frontline associates in these opportunities by the end of 2024.

Finally, in the marketplace category, the company's goal to more than double annual spending with diverse suppliers "reaching best in class levels" is 0.2% from being met. Future plans involve continued investment and involvement with community partners to promote education, economics and health in underserved communities, according to BBU.

— **Gloria Cowdin, Milling & Baking News**

## Gerhard Schubert, packaging industry leader, dies



Gerhard Schubert, the founder and shareholder of packaging machine manufacturer Schubert, passed away in Crailsheim, Germany, on July 4. He was 84 years old.

Mr. Schubert laid the foundation for his company in 1953 with an apprenticeship as a mechanic. He then spent several years gathering experience as a design engineer at the Strunck and Kugler companies before setting up his own engineering and design office in 1964.

Two years later, in 1966, Gerhard Schubert GmbH was founded in Crailsheim. Mr. Schubert built the company into an international group of companies over a period of decades and took the family business to the forefront of the world's packaging manufacturers. In addition to his two sons Ralf and Gerald Schubert, his grandchildren also work for the company.

## BEMA elects new board

At its annual convention earlier this year, BEMA elected new members to its board of directors and its executive committee.

Mark Podl, chief executive officer of Doran Scales, was appointed to the executive committee as third vice chairman. He joins Jim Warren, vice president of Exact Mixing, Reading Bakery Systems, in his second term as chairman; Clay Miller, president of Burford Corp., as first vice chairman; and Jay Hardy, national sales director of J&K Ingredients, as second vice chairman.

Todd Oelschlager, sales director at Corbion, and Jason Stricker, vice president of sales and marketing for Shick Esteve, join the board of directors for their first terms.

Wendi Ebbing, vice president of marketing, Bundy Baking Solutions, was elected to the board to finish the unfulfilled term of Delia Justable, formerly of Forbo Movement Systems, and now product quality assurance manager at Nestle Nutrition North America.

Mike Pierce, president of The Austin Co., was also recognized for serving on the BEMA board of directors for two terms.

## SNAC International announces SNX 2024

SNAC International announced SNX 2024, which will be held April 14-16 at the Hyatt Regency in Dallas.

Held every other year as a complement to SNAXPO, SNX is SNAC International's education and collaboration forum aimed at helping snack brands and manufacturers work together.

"We are pleased to host SNX 2024 and provide a forum for snack professionals to come together to do business more efficiently," said Christine Cochran, chief executive officer of SNAC International. "Not only does this conference foster collaboration and inspire innovation, SNX is the premier business event for industry suppliers and producers to meet one-on-one to discuss current and future business opportunities."

SNX 2024 will include a host of new and returning features for attendees. With Supplier Suites, suppliers at the show can host their own private meeting rooms and arrange meetings with current and prospective snack producer customers. At the Experience Zone, attendees can network and collaborate with suppliers at each stage of production.

Within the Experience Zone will be SNAC Bites, presentations that address the hottest topics and emerging trends in the snack industry. Further discussions on these topics will be held at the show's Education Arena.

The SNAC Tank competition will return as well. Hosted by Daymond John, founder of FUBU and star of ABC's "Shark Tank," the competition allows startup brands to pitch their snack products to a panel of judges for a chance to win \$10,000.



## YOUR RECIPE AUTOMATED TO PERFECTION

Whether it's storing, sifting, metering, weighing, transferring or flour recovery, Shick Esteve is your complete ingredient automation system provider.

FOLLOW US



[shickesteve.com](http://shickesteve.com)





# IN BRIEF

**Del Sol Food Co. Inc.**, Brenham, Texas, acquired Elmwood Park, NJ-based **John Wm. Macy CheeseSticks Inc.**, a maker of baked cheese sticks, cheese crisps and crostinis.

**Ferraro Foods**, Piscataway, NJ, a distributor of specialty Italian foods and foodservice supplies to pizzerias and Italian restaurants, acquired Sussex, NJ-based **GDS Foods Inc.**

Japanese bakery **Taguchi & Co. Ltd.** acquired artisanal New York baking company **Brooklyn Brands**, a subsidiary of Astor Group.

Chicago-based **ADM** opened a new customer creation and innovation center in Manchester, England.

**Baker Thermal Solutions**, Clayton, NC, a Middleby Bakery Co., acquired Saginaw, Mich.-based **BannerDay's** rectification ignitors and SmartBake oven zone controls support inventory and engineering collateral.

Private equity firm **PAI Partners**, Paris, acquired the savory solutions group of New York-based **IFF**. With the completion of the deal, PAI rebranded the savory solutions group as **NovaTaste** with headquarters in Salzburg, Austria.

Tralee, Ireland-based **Kerry Group PLC** opened a taste facility in Karawang, Indonesia.

**Roquette** opened a €4.5 million (\$4.8 million) food innovation center in Lestrem, France.



Thanawala



Stephens



Bentz



Hower



Chaudhry



Cothran



Skadorwa



Foley



Marquardt



Stiller

## People

**Ravi Thanawala** was named chief financial officer at **Papa John's International Inc.**, Atlanta.

**Arjan Stephens** was named president of **Nature's Path**, Richmond, British Columbia.

Hanover, Pa.-based **Utz Brands Inc.** appointed **Jennifer Bentz** as executive vice president, insights, innovation and marketing services.

**Tracy Favre** was named president of the **Organic Trade Association**.

**Niels E. Hower** was appointed as the newest member of the executive board of directors at **Beneo GmbH**, Mannheim, Germany.

York, Pa.-based **JLS Automation** named **Waheed Chaudhry** director of primary packaging. The company also added **Michael Cothran** to its team as regional sales manager, Southeast.

**Kwik Lok Corp.**, Yakima, Wash., named **John Skadorwa** as chief operating officer.

**Brendan Foley** was promoted to chief executive officer of **McCormick & Co.**, Hunt Valley, Md.

**Stephen Marquardt** was named president, managing director and chief executive officer of **Zeppelin Systems USA**, Odessa, Fla. In addition, the company named **Sascha Stiller** as managing director, chief operating officer and chief financial officer.

### A Note to Our Readers

*Baking & Snack* knows how important it is to have timely access to the vital industry information and insights we provide. In addition to our industry leading print editions, you can always stay engaged wherever you are with our digital editions at [bakingbusiness.com/digital\\_editions](http://bakingbusiness.com/digital_editions). You can get the latest news first by signing up for *Baking & Snack's* newsletters by visiting [bakingbusiness.com/Newsletter\\_Subscriptions](http://bakingbusiness.com/Newsletter_Subscriptions). For assistance, please e-mail us at [subscriptions@sosland.com](mailto:subscriptions@sosland.com).

# TOP 5 SNACK TRENDS OF 2023

cinnamon rolls



YouBar

toaster pastries



brownies



cookies



balls & bites



## HOME SWEET HOME

The home baking products market is expected to reach **\$78.3 billion by 2027**.

Packaged Facts



## Black and white and read all over

**88% of diners** prefer paper menus to digital QR codes.

Me8u



## BROWNIE POINTS

3 out of 4 Americans prefer edge brownies over center pieces.

RTA Outdoor Living

## At your convenience

By 2027, convenience store foodservice sales are predicted to hit **\$54.7 billion**.

Mintel



## TASTER'S CHOICE

**49% of US consumers** say taste is the primary driver when deciding what to eat.

T. Hasegawa



# BIG EXPANSION

in a Small Town





## Dutchland Foods adds space and automation as demand rises for its frozen pastries and other goodies.

by Michelle Smith

Tucked in the northwest corner of Iowa surrounded by rolling green hills of corn and soybeans sits the town of Lester, population 309 and home to Dutchland Foods.

The company that started with four members of the Van Wyhe family as a small franchise more than 30 years ago is now thriving, serving fundraising, private label, wholesale and retail customers. The business boom prompted a building expansion and a flurry of new equipment purchases to keep up with the demand for its laminated pastries and other products.

"Most manufacturing today is bigger plants that run one product all day long," said Pete Van Wyhe, president and chief executive officer, who started the company with his wife, Susan, and his parents, Wayne and Jenny Van Wyhe. "What sets us apart is we're more nimble. We do some all-day production runs — and we want to — but we built our business being nimble and listening to customers and making what they want and being a custom shop. Everybody wants their own look."

The plant and processing lines have been upgraded in many ways over the past year with more to come, including added production and office space; a new spiral proofer and two new freezers; a block maker and processing line; a flour silo, chiller and dosing system; and a dough mixer and dumping station.

Although the company plans to remain versatile with customizable products, the sheer volume of business is pushing leaders to focus on higher volume business.

"We have always been a very flexible company, which is evident in the fact that we make around 135 different SKUs," said Monty Van Wyhe, vice president of sales and operations. "We are in a transition stage, though, with a need to increase capacity. As we grow, we realize we may need to cut out some of the lower performing items and streamline our offerings, which we have already started to do."

Dutchland's transition and upward trajectory is one that the business is working through carefully by embracing new automation while staying true to its core values.

### All in the family

The Van Wyhe family established Dutchland Foods in 1992 and began making a laminated pastry under a franchise agreement. The business started selling the pastry via fundraisers for schools, churches and other charities.

"We were farmers and raised on a farm and didn't have any pastry or baking experience other than in the kitchen," Pete Van Wyhe said. "Why we did it exactly, I don't know. It seemed like an opportunity back in 1992. We purchased a small franchise, bought the old bank building here on Main Street in Lester, and we got started."

Pete Van Wyhe handled sales while the others took care of production. The business did well, but expanding into grocery stores was a misstep that hurt the fundraising business because customers could get the products cheaper, so they pulled out of stores.

The current fundraising products, Pastry Puffins and ButterHearts, which account for about 10% of sales, are exclusive to their fundraising customers.

"What sets us apart in fundraising is they are products that you will never find in a grocery store," Pete Van Wyhe said. "They're made differently. They've got a different look, a different name. When a person is buying them on a fundraising sale, they can't even compare us to prices in a grocery store because there's no product there. That's the key to the fundraising market is coming out with a unique product that nobody else has with very high quality."

Toward the end of Dutchland's 15-year franchise agreement, the company was informed that it would not be renewed.

"We had a decision to make whether to get completely out or were we going to retrench and start with our own product lines, and that's what we did," he said. "The franchise was over in 2008, so in 2005 we started working on our own product lines."

The third and fourth generations of the family-owned Dutchland Foods are heavily involved in running the company. Pete and Susan Van Wyhe's three sons run the business alongside Pete, and eight members of the fourth generation are involved as well.

In addition to Monty Van Wyhe, who is in charge of sales and operations, Mychal Van Wyhe is involved in the financial aspect of the business. He also helms the Wyhe's Choice fundraising dealership owned by him and his siblings. Dutchland has 18 dealers around the country selling its products, and Wyhe's Choice is the largest one.

"As kids we were all involved in the fundraising business at one time at a young age. That's what got us into it," Mychal Van Wyhe said. "The five kids bought out the guy

Dutchland produces sweet and savory pastries as well as bulk dough, cobbler and more.

Britton Hacke





From left: Monty Van Wyhe, vice president of operations and sales; Mychal Van Wyhe, involved in finances and Wyhe's Choice fundraising chief; Susan Van Wyhe, co-owner and co-founder; Pete Van Wyhe, president and chief executive officer; and Malachi Van Wyhe, vice president of marketing, are the leaders of Dutchland Foods.

Britton Hacke

who was the local fundraising salesman for the Midwest. He wanted to get out of it."

The brothers and sisters bought the dealership in 1999. Younger brother Malachi Van Wyhe, who was born a year after the purchase, is now vice president of marketing at Dutchland and works heavily in sales, and his wife, Kendra Van Wyhe, works in production.

### Expanding into new areas

Dutchland branched out into producing and selling bulk dough in 2010 and then found new customers through food shows, which opened doors into private label.

"They started asking us to make products for them under their brand," Pete Van Wyhe said. "We'd get a product perfected, then they'd say, 'Now can you do this one?' And that just continued on until this day. We have new customers all the time asking us, 'Can you make this?'"

Private label is now more than three-quarters of the business. The company has the capacity to make new products because it has an in-house mill that can produce unique cutters for its equipment.

"When we started out on our own, the fundraising is all we had," Pete Van Wyhe explained. "It was 100% of our business. But already by 2010 or 2012, that was really

starting to shift because the wholesale business grew as we were making these parts and making more and more new products."

The clean label movement also helped boost sales as many of the company's offerings fit that bill for those looking for premium products. It's still a big selling point today, Monty Van Wyhe said, driving growth in the business.

"We also feel that when the pandemic hit and importing pastries from Europe became so expensive, that we benefited from that as companies looked to find domestic production of their laminated pastry products," he added.

Business was cut in half at the beginning of the pandemic, although government assistance programs at the time helped to avoid layoffs. And a bit of new business arrived when they needed it most.

"By mid-summer some new business came on board that helped carry us into the fall when sales started to slowly pick back up," Pete Van Wyhe said.

The supply chain issues that followed were challenging, but their strong supplier relationships carried them through.

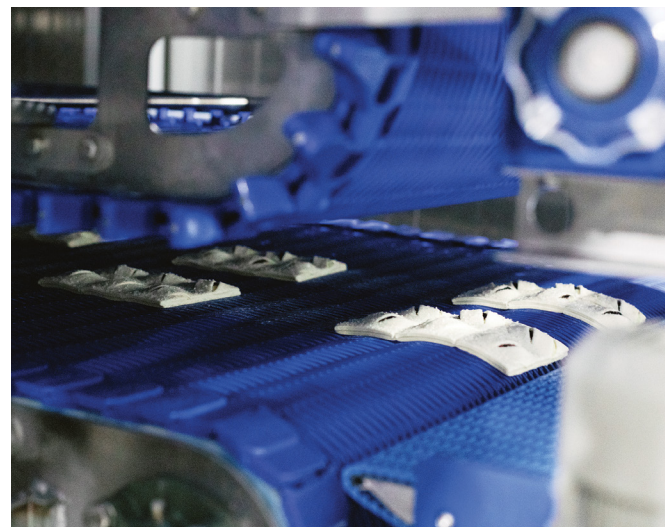
"If you have a good supplier, you want to make sure you stay with them because it's almost like if you switched to someone else and tried to come back to them, they'll say, 'Sorry we can't take your business anymore because we're maxed out,'" Monty Van Wyhe said. "It's all about relationships."

### Backbone of the company

Dutchland employs 84 people, and most are full-time. The company's part-time workers help to bulk up staff levels on days when more manual labor is needed on the production floor.

The spiral proofer and freezer was installed in July, which takes product directly from the line to the proofer and freezer.

Dutchland Foods





# “I’m really a production guy at heart.”

Rick O’Boyle has been with Ross for 29 years, but he spent his first 11 years in manufacturing before moving into technical sales. This experience gave him a deep understanding of the real-world production challenges our customers face every day.

Ross Regional Sales Managers are all full-time, salaried experts who will consider your whole production environment – then suggest the right mixing technology and equipment design to meet your process goals.

Contact Ross today to put our experience to work in your plant.  
Call 1-800-243-ROSS or visit [mixers.com](http://mixers.com)

Try our Knowledge Base & Product Selector  
web app: [mixers.com/web-app](http://mixers.com/web-app)

Rick O’Boyle  
Regional Sales Manager  
29-Year Ross Veteran  
Employee Owner



Scan to learn more.



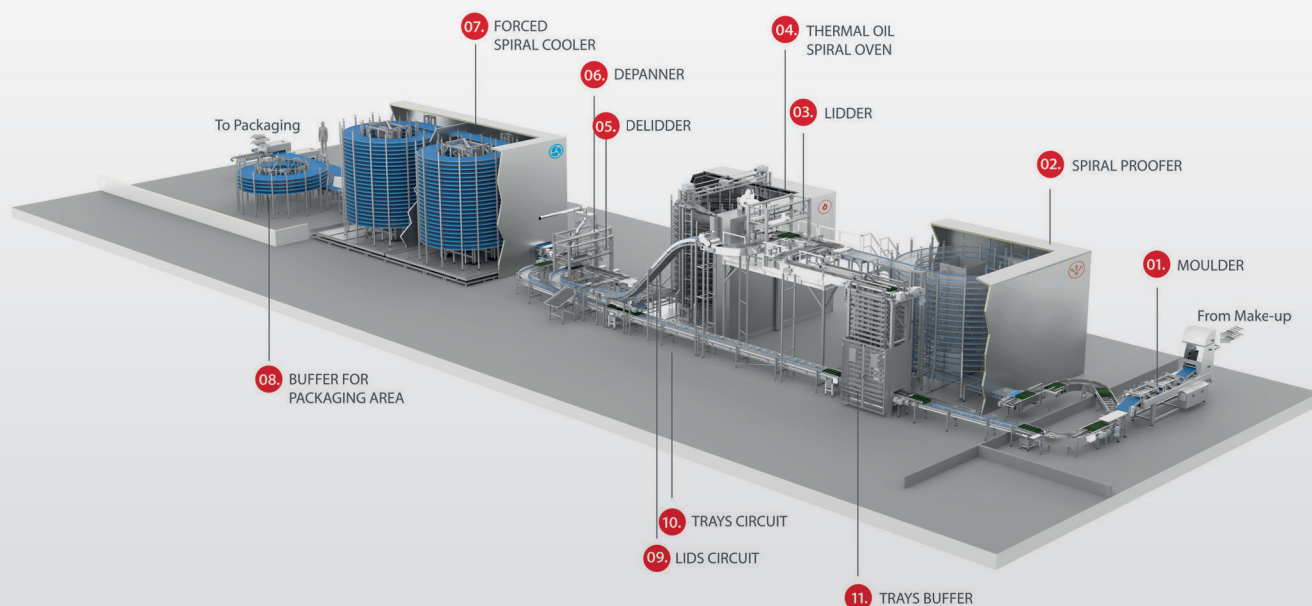




The only limit  
is our customers'

# IMAGINATION

We design, deliver, and support tailor-made solutions for industrial food processing:  
**from single systems to complete lines for your business.**



[tpfoodna.com](http://tpfoodna.com)



## "THERE WAS A LOT OF THOUGHT AND PLANNING PUT INTO THE BUILDING EXPANSION AS WELL AS THE NEW EQUIPMENT."

Monty Van Wyhe, Dutchland Foods

"With our products, we might make one product by hand one day and we need 30 production workers, and the next day we're making a product that's all automated and we only need 15," Monty Van Wyhe said. "You have this swing, so you need part-time people to fill in the highs and lows."

Workers are drawn from Lester and other nearby small towns, and many part-timers are homemakers interested in working just a few days a week, Pete Van Wyhe said. Finding workers had not been much of a problem, although the last two years have been a bit harder with Iowa's low unemployment rate. It was 2.7% in May, according to the US Bureau of Labor Statistics.

"Over the years, we've hardly ever advertised," he said. "We would just keep a list of people who contacted us and keep their applications. I do think the work ethic is very good in the Midwest. I love the people who work here; they're the backbone."

The Van Wyhes strive to create a family environment for employees, providing pastries at work and hosting events like potlucks and pizza parties. Although the plant is automating, the company doesn't anticipate cutting workers at this time.

"We always worry about that every time we've added a piece of equipment," Pete Van Wyhe said. "We think, 'We may have to lay off a few.' And you know what? It's never happened. We find them other work, and we continue to grow."

Scheduling production can be tricky as the company makes about 50 different types of pastries as well as pie dough, bulk dough and fruit cobblers. About 90% of the products Dutchland makes are laminated pastries, including puff pastries, croissants and Danish.

The plant runs one shift, 7 a.m. to 4 or 5 p.m. Mondays through Fridays with occasional Saturday shifts, but those working in mixing get in around 4:30 a.m. to ensure the doughs are ready for processing by the time the regular shift begins. Business is steady year-round, but it picks up in the fall with the fundraising products and demand for retail pie dough.

"The fall gets more hectic because you do have the holiday bump. It's a peak time," Monty Van Wyhe said. "For the scheduler, there are two things he has to balance: He has to look at our inventory levels and orders but also allergens. We color code all our allergens on the schedule."

The USDA- and BRC-certified facility employs 10 full-time members on its sanitation staff, which starts at 4 p.m. and

## The Secret to Safe, Smooth Conveying is Volkmann



A lot of our customers can't talk about their secret to safe, smooth, gentle conveying but everyone knows the secret is Volkmann. Our patented pneumatic vacuum conveyors automatically transfer powders and other bulk materials from one point to another in fully enclosed, dust-tight, explosion-proof systems.

- Automated, hygienic and quiet
- Easy to use, easy to clean
- No tools disassembly
- Stainless steel as standard
- Fast lead times, easy to install



See action videos, get free test at [Volkmannusa.com](http://Volkmannusa.com)

[Volkmannusa.com](http://Volkmannusa.com) | 609-265-0101  
1900 Frost Road, Suite 102, Bristol, PA 19007





works until midnight. The BRC designation has helped secure business from larger customers, and maintaining it requires rigorous attention to detail.

"Today, food safety is running the plant," Pete Van Wyhe said. "When you're dealing with high-end customers, they demand that you are with a strong auditing company, and we've gotten AA ratings (BRC's top rating), and I give credit to our food safety team. They are tops. But it governs everything, from the weeds that might be outside the plant to the shoes you wear."

### Busting out with automation

Evidence of the recent expansion and new equipment is everywhere at Dutchland, which sits on Lester's Main Street. Dutchland added to its facility in 2003 and last year added about 12,000 square feet of production space and 5,000 square feet of office space. The original bank-turned-bakery building is now the employee break room.

"We started researching and planning the expansion around the fall of 2021," Monty Van Wyhe explained. "There was a lot of thought and planning put into the building expansion as well as the new equipment we wanted to purchase."

With the building complete, much of the equipment is up and running, but more is on the way in the next several months. The 17,000-square-foot warehouse across the street, which was built in 2019, will have two loading docks

---

Dutchland relies on manual labor for some products, like these ham and cheese pastries.

Britton Hacke

## DUTCHLAND CREATES ONE-OF-A-KIND PRODUCTS

One of the keys to the success of Dutchland Foods' thriving private label business is its ability to create unique products for its clients. A big part of that was the investment in a Haas CNC Machine mill, which allows Dutchland to make new cutters in house for the processing table and create unique products for clients.

"We're making a lot of parts continually for new customers," said Pete Van Wyhe, president and chief executive officer. "That's basically what these private

label customers want."

The company can mill out the attachments and save the time and money it would take to order a new part.

"We can become very customizable very quickly," said Malachi Van Wyhe, vice president of marketing.

When developing a new product, sometimes Dutchland gets a recipe they must stick to, so they develop the formulation that works with their processing. Other times, customers will tell them what they want, and the company develops a

formulation and trades notes and samples back and forth until they get it right. Several staff members get involved.

"It's one of those things where people wear multiple hats," said Monty Van Wyhe, vice president of sales and operations. "We are getting to the point where we may need to hire a full-time R&D person. We have brought in consultants over the years, such as a French pastry chef who understands croissants and the science behind it and helped us improve our quality."

# ONE CONTINUOUS PERFECT BAKE FROM END TO END



MIDDLEBY'S TURNKEY  
BAKERY SOLUTIONS HAVE  
GOT YOU COVERED.

Middleby optimizes best in the industry *end-to-end solutions* and provides you with *top tier lines* for all your baking needs, with complete customer support throughout equipment development, installation, and production.

## TOP OF THE LINE

Breads | Buns | Cookies | Crackers | Cakes | Muffins | Pastries | Pies | Pizzas

See you at **iba** Munich, Germany, Oct. 22-26, Stand B1.150 & B1.170!

 **AUTO-BAKE  
SERPENTINE®**

High Capacity Serpentine  
Solution for all Bakery Categories

**Baker**  
THERMAL SOLUTIONS

Proof | Bake | Cool

*Burford*

Pan Shakers | Topping Applicators  
Water Splitters | Closure Systems

 **COLUSSI ERMES**

Washing | Sanitizing  
Drying

**ESCHER**

Professional Mixers

 **Glimek**

Bread Dough  
Make-up Machinery

**HUNGRY  
FOR MORE?**

 **HINDS-BOCK**

Deposit | Portion | Fill |  
Pump

 **Key-Log**

Automated Logistic  
Solutions

*pacproinc*

Interleaving | Stacking  
Interleaving Materials

 **PROXAUT**

Automated Guided  
Vehicles

**SCANICA**

Freeze | Chill  
Steam | Proof

**SPOONER  
VICARS**

Complete Biscuit &  
Cracker Solutions

 **STEWART  
SYSTEMS**

High-Capacity Bread and  
Bun Conveyorized Systems

**SVEBAE  
DAHLEN**

Professional Baking  
Machinery

**VEMAC**

AGV Robot  
Loading | Unloading







added this year in addition to the two already there. And the warehouse staging area has been expanded to create more room for shipments and deliveries.

Dutchland is also buying the building that housed Wyhe's Choice fundraising, which vacated to move into a new, bigger building in town. There are no current plans for that space, but it could be used for further expansion down the road.

Currently in the warehouse, operators make bulk dough twice a week using a 400-lb Rondo mixer and Rondo block line, which can produce 12,000 lbs of laminated dough in an eight-hour shift. A Vimek spiral freezer — like the new one that was just installed across the street — is going in for this line so the doughs can go straight into the freezer to be flash frozen, an improvement from the current labor-intensive method.

"The way we have to freeze it now is every block has to get trayed up and pushed into a -10°F freezer," Monty Van Wyhe said. "Then the next day you take it back out, take every slab off the tray and package it."

A 500-lb Mixer brand mixer is used to make fillings for the pastries and an ABS mixer sits ready to fill in as needed. The warehouse has the largest freezer onsite with space for 104 pallets, and a 60-pallet cooler stores eggs, cream and other ingredients. More freezer and cooler space is available across the street in the main building. The warehouse also has dry storage and a staging area with an Orion pallet wrapper.

More than 90% of Dutchland's products are stored in a freezer warehouse 45 minutes away in Worthington, Minn., before they are shipped to customers. A freezer warehouse is in the plans for Lester, but that's a few years down the road.

The main production building houses a 76,000-lb capacity Agriflex flour silo, chiller and dosing system, which were installed in January, saving labor and storage space. Bowls from the 617-lb capacity Mixer are rolled under the dosing station for flour, then other in-

---

Top: Dutchland Foods produces about 50 different types of pastries.

Dutchland Foods

Bottom: Dough had to be added manually before Dutchland bought and installed a new mixer and dumping station earlier this year.

Dutchland Foods



OFFERS SUPERIOR SUPPORT PLUS SIMPLE & EASY JOINING,

# **COMPACT-GRID™**

## **IS THE BELT FOR BAKING!**

- Maximum support for small products
- Belt installation is fast and simple!
- Clean-in-place, USDA accepted
- Excellent belt tracking, positive drive design
- Open area allows for excellent flow-through
- **Available in 10MM and 15MM meshes**



**Wire Belt Company of America**  
17 Colby Court, Bedford, NH 03110  
(603) 644-2500 | [sales@wirebelt.com](mailto:sales@wirebelt.com)  
[www.wirebelt.com](http://www.wirebelt.com)





ingredients are added manually before mixing then onto the Mixer dumping station. Both the mixer and dumping station were installed in February. Before that, the dough had to be added manually.

The dough then goes onto the Rademaker block maker line where butter is added to produce the laminated doughs. The doughs then go into either the cooler or freezer to rest for 45 minutes to a few hours, depending on the product.

The chilled dough slabs are then loaded onto the Rademaker block processing line. The day of *Baking & Snack's* visit, the dough bands were double-stacked like bricks to provide more layers for the savory lattice croissants being made. This line can make up to 110,000 pieces a day, although the line goes slower when manual labor is needed, like with the croissants that are filled by hand.

The makeup table now produces a 26-inch-

Sweet pastries go from the proofer to the freezer.

Dutchland Foods

**Rademaker**  
Specialists in food processing equipment

## High quality laminated dough products

- ✓ Flexible line lay-out
- ✓ Fast and Easy cleaning
- ✓ High production efficiency

VISIT US AT  
BOOTH C2.350

2023  
22-26.10.  
Munich  
www.ifa.de

INNOVATIVE PRODUCTION LINES FOR

BREAD FLATBREAD LAMINATED DOUGH PASTRY CROISSANT PIZZA PIE



# OVER 100 YEARS OF SUPERIOR VALUE



- AUTOMATIC INGREDIENT HANDLING SYSTEMS
- DOUGH CONDITIONING SYSTEMS
- AUTOMATIC WATER METERING AND TEMPERATURE BLENDING SYSTEMS
- IN HOUSE ENGINEERING, DESIGN, MANUFACTURING, AND SERVICE



THE FRED D. PFENING COMPANY  
1-866-PFENING (1-866-733-6464)

EMAIL: [SALES@PFENING.COM](mailto:SALES@PFENING.COM) • [WWW.PFENING.COM](http://WWW.PFENING.COM)



## "WE ALWAYS HAD THE THOUGHT THAT IF WE TAKE CARE OF OUR MISTAKES AND TREAT CUSTOMERS RIGHT, WE'LL TURN THEM INTO A CUSTOMER FOR LIFE."

Pete Van Wyhe, Dutchland Foods

wide band for processing, but it will be replaced later this year with a 39-inch Rademaker line that will increase throughput and consistency. Also on the way is a new Form & Frys Odin machine, which will automate the process for crowns and turnovers, which were folded by hand previously. The machine can be wheeled on and off the line.

Product then goes directly into one of the plant's newest pieces of equipment, the Vimek spiral proofer and freezer, which was installed in July.

The frozen items are then either bagged or boxed, depending on the product, which is a mostly manual process, and then travel through an Avery checkweigher and

a Sentinel 5000 metal detector. Company leaders are planning to add automation to the packaging department, but that is likely a year or more away.

A second line used occasionally makes the company's lard-based pie dough, which is sold at stores under the Dutchland brand, Pappy's Pie Dough. Once mixed, the pie dough runs through a Reiser Vemag extruder, which turns the dough into pucks that can be rolled out by the consumer. They are trayed, go through an Ilapak flowwrapper then frozen. An Orion pallet wrapper serves the main production building.

As the Van Wyhes watch their careful planning come to fruition, they are already looking to the future with more automation and expansion on their wish list. But what won't change is their path of producing high-quality treats and taking care of their customers.

"We always had the thought that if we take care of our mistakes and treat customers right, we'll turn them into a customer for life," Pete Van Wyhe said. "We just want to be honest, hardworking, treat our customers right and let the business go where it goes."

## QA Series In-Line Sifters

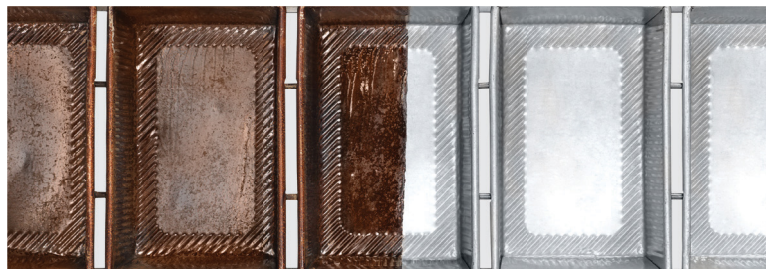
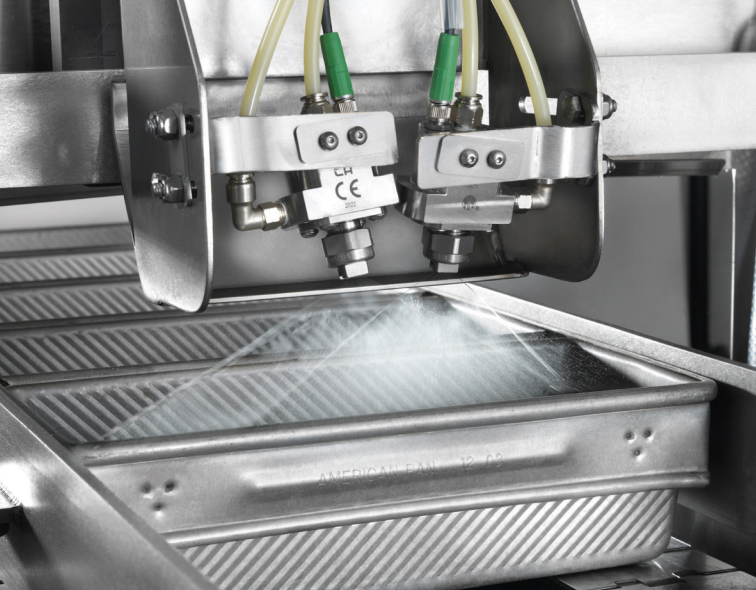
- Stainless steel construction of all product contact areas with very few weldments.
- Interlocking sieve frames enable you to quickly and completely dismantle the machine in minutes.
- Hinged guards on the front and back of the machines provide liberal access while keeping plant personnel safe.
- Stainless steel screen frames use glued on screens for the optimum in sanitation, sifting performance, cleaner



We offer customization of our standard equipment to suit your installation and process requirements.

[gwmfg.com](http://gwmfg.com) [sifter@gwmfg.com](mailto:sifter@gwmfg.com) (800) 682-3121





# Maximize the Life of Your Pans

## with Synova & Pan Glo®

Using Synova's release agents and applicators along with a Pan Glo® pan cleaning schedule, your bakery can take control of oil usage and ensure pans are always achieving their best and longest release life.



### SPECIALTY FORMULAS

Synova's release agents are formulated specifically for baking and come in a variety of special formulas.



### IMPROVED APPLICATION & RELEASE

Synova's release agent applicators use precise metering and placement to reduce oil usage while improving pan coverage and release.



### PAN SERVICE PLAN\*

A Pan Service Plan provides bakeries with a rotating supply of clean and recoated pans from Pan Glo to better manage oil usage and keep product quality consistent from the first bake to the last.

*\*Using DuraShield® coating? We have a plan for that too!*



Visit us in Hall B1 - Stand 110!



## Synova | Pan Glo

+1.937.652.2151 | [info@bundybakingsolutions.com](mailto:info@bundybakingsolutions.com)  
[bundybakingsolutions.com](http://bundybakingsolutions.com)



LEARN MORE





# LEANING POWER OF PIZZA

Innovation in crusts, flatbreads and frozen dough fuels consumer purchases in the highly competitive pizza market.

by Dan Malovany

No matter how you slice it, the battles for dominance in the world of pizza are fought with toppings. But the war is won with what comes underneath the perennial top-selling mainstays of pepperoni, cheese and supreme varieties or a lesser-known hot honey barbecue or globally inspired tandoori pie.

“Crust type leads the decision-making process for consumers when shopping their local frozen pizza aisles,” observed Maddie Essman, senior marketing manager for Schwan’s Consumer Brands Inc.

During the past few years, the Red Baron brand has introduced several different varieties, including its Stuffed Crust Pizza and Fully Loaded Original Pizza. Now, Bloomington, Minn.-based Schwan’s is in the process of launching Red Baron Fully Loaded Hand Tossed Style Crust Pizza, which is an extension of its Fully Loaded Original Crust Pizza that debuted in 2021.

“We noticed there are a significant number of consumers who seek out hand-tossed pizza within the restaurant pizza industry,” Ms. Essman explained. “It is the No. 1

selling type of crust in pizzerias and quick-serve restaurants across the United States. However, the crust style accounted for less than 1% of frozen pizzas in the market.”

She added that the hand-tossed style pizza crust is soft and chewy but crisp enough on the bottom so there is no “flop” when holding up a slice. It’s designed to be an indulgent, restaurant-style experience that provides consumers with a distinct option from the brand’s original pizza crust, which Ms. Essman described as “crispy and airy — like a deep-dish pan-style pizza.”

From a market researcher’s perspective, “it’s all about the crust” when it comes to consumer preferences, according to Mintel’s 2022 report on the US pizza category.

“While a substantial portion of retail pizza consumers express interest in premium toppings and unique varieties, those concepts are likely to fall flat if the crust isn’t right,” the study concluded.

It’s also been a heck of a ride for the pizza category during the past three years. Mintel’s report noted sales of retail pizza, including frozen pizza, refrigerated take-





and-bake pizza, and pizza kits and components spiked in 2020 during the pandemic with a 24% surge that outpaced the gains by many other food categories. After sales eased in 2021, they shot up in 2022, driven by inflation, while unit sales fell back to pre-pandemic levels.

That's still the situation in the freezer case this year. Frozen pizza sales rose 10.2% to nearly \$6.9 billion while units slipped 3.1%, according to Circana data for the 52 weeks ending May 13. The average price per unit jumped 13.7%, more than making up for any unit decline.

"When you think about a 10% increase and losing 3% in unit sales, that's incredible," said Sally Lyons Wyatt, executive vice president and practice leader for client insights at Circana. "It shows that pizza still has staying power for the category in the stores."

Convenience and affordability are the key forces behind the frozen pizza segment's strength.

"Consumers have it in a freezer in their own homes, and they can get it when they want it and bake it when they want it," she added.

Meanwhile, deli department pizza is firing on all cylinders, rising 16.5% to almost \$2.1 billion while unit sales climbed 8% during the past year, according to Circana. Whole pizza sales surged 17.1% to \$1.2 billion with a 9.9% hike in units. Individual slices grew 16.1% to \$532.2 million, while units rose 6.8% in the deli. The smaller all-other pizza segment also expanded at a dou-

ble-digit rate while sales of deli calzones declined.

Ms. Lyons Wyatt suggested affordability provides another driver for deli pizza sales, especially for those consumers who are commuting to work more often.

"A deli slice is \$2.63 on average and a full pizza is \$7.51 in the deli on average, but a frozen pizza is \$4.97, so it's still more economical to buy frozen versus fresh," she explained. "However, when you're ready to eat and you're getting something for that 'just now,' fresh is winning."

Frozen and deli pizzas provide a convenient meal replacement, but companies need to better engage consumers to build excitement and expand sales in the long run.

©Daria Belkina-stock.adobe.com

## A world of difference

Overall, pizza makers have been focusing on creating different types of crusts in recent years.

"We see more innovation around the crust itself," Ms. Lyons Wyatt said, "so you might have a filled crust or pretzel crust or flatbreads."

Nestlé USA, Arlington, Va., offers a full variety of crusts under its brands, which include DiGiorno, California Pizza Kitchen, Jack's, Lean Cuisine, Life Cuisine, Stouffer's and Sweet Earth.

"As a category leader known for its crust, DiGiorno is constantly reimagining how to bring fan-favorite pizza styles to people's kitchens," a company spokesperson said. "The brand recently launched two new pizza varieties to address the ongoing debate of thick crust versus thin crust."

Nestlé is focusing its innovation strategy around three consumer trends. First, indulgent options like DiGiorno Fully Stuffed Crust Pizza provide "over-the-top taste," the spokesperson said. Second, the company is looking at new eating occasions with the expansion of its DiGiorno personal pizza line, adding two new Hand-Tossed Crust Style varieties, including BBQ Recipe Chicken and Chicken Alfredo, to elevate snack time. The third includes dietary preferences with such varieties as DiGiorno Gluten Free Crust Pizza, Life Cuisine Carb Wise Keto-Friendly Veggie Pizza and Sweet Earth plant-based pizzas.

"People's dietary preferences are constantly evolving, as consumers look for convenient options that meet those lifestyle changes," the spokesperson explained.

At Molinaro's Fine Italian Foods, the world of pizza is not only round, but flat and rectangular. Based in Mississauga, Ontario, the company offers 6-by-12-inch stone-baked flatbreads that come in such varieties as Buffalo Style, Bruschetta or Spinach and Cheese, to name a few, along with other custom-made toppings for private label store brands.

"The flatbreads could be used for entertaining or sliced for an appetizer, but they can also be used as a pizza for dinner," said Joe Delduco, vice president of sales and marketing. "You just take two or three out, and they all fit in the oven at the same time."

These flatbreads also provide more portion control than conventional pizzas.



## PIZZA



Schwan's recently introduced Hand Tossed Style pizzas to bring the popular restaurant-style crust to the freezer case.

Schwan's Consumer Brands

"Most people aren't going to eat a 12- or 14-inch round pizza, but they may buy two flatbreads because they're smaller portions and they're cheaper," he said.

For in-store bakery/delis and foodservice operators, New York-based Vandemoortele USA offers everything from thick focaccia, ciabatta and pizza crusts to pinsa, a light and airy sourdough created with a biga starter, made in its bakeries in northern Italy.

"Pinsa is definitely a trend," said Johan Coppens, master baker and culinary/technical adviser for Vandemoortele Europe NV, Ghent, Belgium, during the recent 2023 International Dairy Deli Bakery Association's show. "I see more pinsa being made both here in America and throughout Europe, and that's because it's naturally delicious. It's just water, salt, flour, olive oil and biga, instead of yeast."

Other pizza producers are taking a crust-centric focus. Home Run Inn sells its frozen Nothing But Crust in a two-pack carton. In addition to placing menu ideas on the package, the Chicago-based company encourages consumers to create their own versions of the Windy City's classic on its signature buttery crust. Meanwhile, New York-based The Pizza Cupcake, which appeared on "Shark Tank" a few years ago, is expanding nationally with cupcake-shaped items that come in margherita and pepperoni flavors and in a brioche-style dough.

## AXIFLOW TECHNOLOGIES, INC.

### OUR NEWEST ADDITION: DRUM UNLOADER

- 50 + gpm Unloading
- Discharge Pressures up to 375 Psi
- Product Viscosities Over 500,000 cPs
- Can Transfer Soft Solids up to ¾"
- Variable Plate Sizes to Pump Out 75, 55, 30, 20 & 16 Gallon Plastic, Metal & Fiber Drums
- Custom Plates for Pumping out Totes and Tanks
- Completely CIPable



Booth  
#N-10161

#### LEARN MORE:

1-855-Axiflow • [www.Axiflowtechnologies.com](http://www.Axiflowtechnologies.com)  
[info@axiflowtechnologies.com](mailto:info@axiflowtechnologies.com)



# Extend product freshness with superior packaging technology from Reiser



Take your business to the next level with Reiser packaging

## Reiser Form/Fill/Seal Packaging Machines

- Wide range of flexible machines produce high-quality vacuum, MAP and VSP packages
- High-speed production
- Superior seals eliminate leakers and returns
- Backed by Reiser's industry-leading service and support



Watch  
video

[www.reiser.com](http://www.reiser.com)

Reiser • Canton, MA • (781) 821-1290

Reiser Canada • Burlington, ON • (905) 631-6611

Reiser UK • Milton Keynes, Bucks • (01908) 585300







Companies offer a wide variety of pizza crusts for entertaining and for multiple eating occasions throughout the day.

Nestlé



Such creativity is needed to elevate the experience and drive sales in this category.

"There's room to enhance retail pizza's image both as an indulgent treat and as a healthy meal option," noted John Owen, associate director, food and retail, Mintel, in the 2022 pizza report. "Innovation in both these directions will help the category attract more users and capture new-use occasions."

### Making pizza more value-able

With persistent inflation, Ms. Essman expects budget-conscious consumers to search for more frozen pizza options.

"We are seeing consumers trading out of restaurant pizza and into premium frozen pizza," Ms. Essman said. "These consumers can still get a great pizza but at a fraction of the price by switching over."

She also noticed an increase in value pizza consumption to reduce grocery expenses.

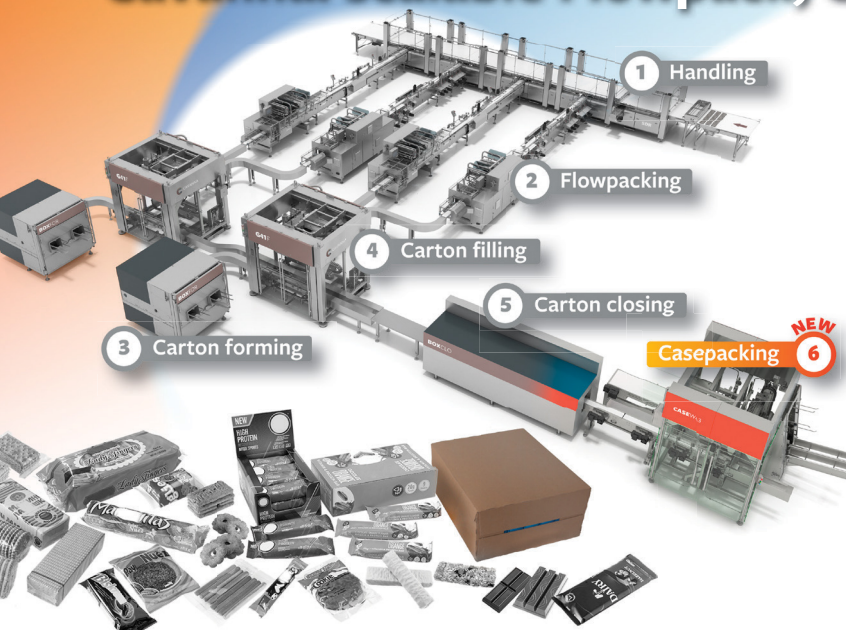
"Consumers can purchase a Red Baron pizza for around \$5 and a Tony's pizza for around \$4," Ms. Essman said. "These options present affordable and delicious pizzas that the entire family can enjoy."

Mintel noted that nearly three quarters of those surveyed reported that their household has eaten pizza from a supermarket in the past three months.

But here are two key observations to consider. More than three quarters of retail pizza consumers agree that delivery pizza tastes better. Mintel stated this suggests that delivery remains the standard for judging retail pizza quality.

Secondly, the report pointed out that nearly half of re-

## Cavanna: scalable Flowpack, Cartoning & Casepacking



**Cavanna Packaging** specializes in:

- Turn-key Flow Wrapping, Cartoning and **6 Casepacking** solutions
- Sanitary Design Systems for the Food Industry
- Easy to clean toolless Poke Yoke solutions
- Fully Caustic Washdown Flow Wrapping lines
- Unique space and labor saving Flow Wrapping solutions



**CAVANNA**  
Turn-key Flowpack & Cartoning

**CAVANNA PACKAGING USA INC.**

3400 Corporate Way | Suite F | Duluth GA 30096 | Phone: (770) 688-1501  
Fax: (770) 810-3528 | sales@cavannagroup.com | www.cavanna-usa.com

Linked



# QUANTUM



## **MLT2000** TARGET WATERFALL TOPPING APPLICATOR

Quantum's MLT2000 Multi-Lane Target Waterfall Topping Applicator deposits a variety of toppings such as cheese, IQF vegetables and meats onto product at speeds up to 60 feet per minute, per lane. The MLT2000's 'no tray, no fill' capability reduces waste, increases productivity and ensures consistent coverage. Portable and compact, the MLT2000 can cantilever over existing lines.

**QUALITY PORTION  
AND APPLY  
SYSTEMS FOR YOUR  
APPLICATIONS**

**MLT2000**  
TARGET WATERFALL  
TOPPING APPLICATOR



**QT6A5**  
DRY/GRANULAR  
INGREDIENT APPLICATOR



**TC-5S**  
TARGET WATERFALL  
TOPPING APPLICATOR



**QTMC5**  
CONVEYORIZED TARGET  
SAUCE APPLICATOR



# QUANTUM®

9524 GULFSTREAM ROAD | FRANKFORT, IL 60423  
815.464.1540

[WWW.Q-T-S.COM](http://WWW.Q-T-S.COM)



**MORE  
INFO**



# Say Ciao to Stubborn Crusts

Serve up the perfect slice all day, every day with Release Agent and Equipment solutions from Vantage® Food.

- **Improve product consistency**
- **Decrease waste and cleaning frequency**
- **Extend the life of your pans**

To learn more, contact us at: [info.food@vantagegrp.com](mailto:info.food@vantagegrp.com)

Our integrated approach includes industry experts, processing ingredients, and precision spray equipment that help increase operational efficiency and your peace of mind.

Better Pizza  
Made Possible



tail pizza consumers said they would like to see more refrigerated and frozen pizza with extra toppings, indicating that some consider retail pizza could be “skimpy” on toppings. Mintel mentioned products that promise and deliver extra cheese or toppings are likely to have a more receptive audience. Perhaps that’s why many brands offer “loaded” or extra toppings options.

Unpredictable ingredient costs, however, make value-added a tricky proposition.

“We have to find ways to defray additional price increases because we’re going to price ourselves out of consumers’ pocketbooks if we keep increasing double digits, so the way to do that is through penetration, buy rate and frequency,” Ms. Lyons Wyatt observed. “We need to find a way to get into new homes and/or to get the households that are purchasing pizza to buy it more often or buy more when they purchase it. That may require buy-one-get-one or buy-three-get-one promotions, or another type of promotion to drive incremental units.”

Ms. Essman pointed out the peak seasons for frozen pizza bookend the year.

“Each calendar year starts strong as large sporting events in football and basketball create moments where consumers look to frozen pizza to feed their families and friends,” she explained. “As students return to school in late summer or early fall, families look to frozen pizza as a delicious, convenient option. This uptick in consumption continues through [the fourth quarter] as frozen pizza consumers look for options to cut down on meal prep and have crowd-pleasing options as they gather with their loved ones during the holidays.”

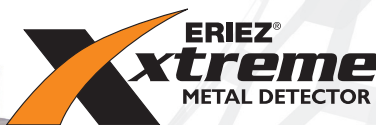
In such a competitive market, Mr. Delduco said the private label segment needs to differentiate itself.

“The challenge is that national brands are acting like private label brands,” he said. “These national brands are on promotion 70% to 80% of the time so you can get a national branded pizza anytime on sale.”

He added slightly smaller sizes, such as a 10-inch pizza, provide about the same net weight as a 12-inch variety and allow retailers to charge a more affordable, everyday low price.

Moreover, Molinaro’s now offers a Neapolitan crust

# Xtreme Versatility Metal Detectors for every process



## Xtreme Metal Detector Advantages

- Best-in-Class Sensitivity
- Easy Setup and Operation
- Multi-Language Interface
- Remote Factory Support



Liquid Line



Vertical Flow



Vertical Fill & Seal

Eriez.com | 814.835.6000

# ERIEZ





Simple ingredients lay the foundation for creating a wide variety of traditional and innovative, often wholesome pizza crusts.

Atoria's Family Bakery

that's fluffier and softer than what's in the market as well as spicy Tandoori, Korean BBQ and other niche varieties that cater to regional preferences.

"We like to say, 'We're not here to duplicate anything. We're here to fill that void,' but the customer needs to tell us what that void is," Mr. Delduco said.

### Fresh and custom made

In the deli, freshly made pizzas cater to consumers who plan to eat them immediately or heat them up after they get home from work. For British Columbia-based Pace Processing & Product Development, a part of Toronto-based Bond Bakery Brands, take-and-bake remains a key focus area with its Artisan Hand Panned Pizza products at the forefront.

"Consumers are looking for quality products in the HMR [home meal replacement] set that provide value when compared to the products that can be purchased within the restaurant or foodservice space," said Sean Darrah, president, Pace Processing.

Atoria's Family Bakery, Gilroy, Calif., focuses on using simple ingredients to bake its pizza crusts, naan, lavash and other flatbread that are convenient for putting together a pizza, meal or snack, noted Lilea Eshoo, chief operating officer.

"People have busy schedules and are often looking for the quickest and easiest meal to throw together," she said. "Our pizza crust is perfect for that while also delivering on taste. We've also noticed that making pizza at home is on the rise. All of our flatbreads make a perfect crust for an easy, homemade pizza night."

Atoria's offers a Cauliflower &

# HOW

# WE CUT

# CARBS

## Stacked Solutions. Superior Support.

You can't buy happiness, but you can buy pizza! And a low carb pizza is not out of reach. When you replace flour with Manildra's GemPro wheat proteins and FiberGem resistant starch you can create a low carb pizza without removing any of your favorite pizza characteristics. Manildra's stacked solutions ensure your product rises above the competition.

800-323-8435 | [info@manildrausa.com](mailto:info@manildrausa.com)



**MANILDRA GROUP**  
USA

[www.manildrausa.com](http://www.manildrausa.com)





# AIM TECHNOLOGY **FOR PIZZA**

**Automation for pizza handling that no one else can deliver.**



Active Integrated Motion™ (AIM™) technology transforms frozen pizza handling by enabling automation in washdown environments.

Intralox® AIM solutions include sorting, switching, and merging equipment that deliver maximized, reliable throughput and gentle product handling to your pizza packaging lines.



Scan QR code to learn more.

**> RELIABLY INVENTIVE**



## "PEOPLE HAVE BUSY SCHEDULES AND ARE OFTEN LOOKING FOR THE QUICKEST AND EASIEST MEAL TO THROW TOGETHER."

Lilea Eshoo, Atoria's Family Bakery

Coconut Mini Lavash that became so popular among low-carb consumers that the company created a Cauliflower & Coconut keto-friendly pizza crust. For making personalized pizzas, it's rolling out Mini Naan that is available in Traditional and Upcycled Multigrain, which is made from grains rescued from the end of the beer brewing process.

Additionally, its Cinnanaan, a cinnamon and sugar variety, can be transformed into dessert pizzas topped with fresh fruit.

"Upcycling is a newer idea around the US, giving it plenty of opportunity to rise," Ms. Eshoo said. "Food

waste is something that concerns 99% of Americans, and choosing upcycled products is one small way to divert food waste and reclaim high-protein, high-fiber grains by giving them this second life. Pizza in itself is a resourceful way to use up odds and ends in the fridge and prevent waste so this item is truly a win-win for consumers looking to lessen their footprint."

The better-for-you segment can incrementally grow the category, but it's a constantly shifting landscape.

"In the frozen aisle, interest in No-Carb Pizza products continues to see higher traction among consumers, while select offerings, such as gluten-free, for example, seem to have slowed down and have potentially reached a peak," Mr. Darrah said. "Better-for-you pizzas remain a small category segment for Pace Processing. One barrier we see to the category, in our experience, is the perception of consumer value relative to the higher price point for select customers."

By rolling out new products that pique consumers' curiosity, pizza makers can not only win the battle but also the war in the pizza market. ●



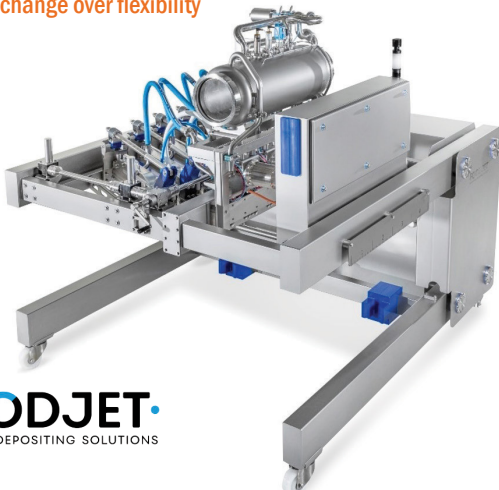
**CREATING CUSTOM SOLUTIONS SINCE 1972**

[www.geminibakeryequipment.com](http://www.geminibakeryequipment.com) • 215.673.3520

**#WeDoughItAll**

### NEW! FoodJet Precision Sauce Depositor

- High speed precision placement
- Compatible with various types of sauce and puree
- Instant change over flexibility



**FOODJET**  
PRECISION DEPOSITING SOLUTIONS



**Knowledge ✨ Passion ✨ Legendary Customer Service**





# the PERFECT BLEND

CUTTING EDGE TECHNOLOGY AND THE ART OF OLD WORLD BAKING

Sours | Dough Improvers | Bases, Mixes, Concentrates | Grain Blends | Tortillas | Clean Label, Organic, Non GMO

## pizza crusts

Pizza crusts come in all textures and flavor profiles, and Brolite can find the perfect blend for your bakery. Whether it will be made fresh or frozen, Brolite provides a variety of natural fermented flavors, bases and dough conditioners to help keep your crust consistent and perfected to suit your needs.



1900 S. Park Ave. | Streamwood, IL 60107 | Toll Free (888) 276-5483 (630) 830-0340 | [www.bakewithbrolite.com](http://www.bakewithbrolite.com)



SQF Level 3  
food supplier &  
certifiable organic  
products





# a natural fit

Bakers win over increasingly health-conscious consumers with natural sweeteners.

---

by Lucas Cuni-Mertz

Consumers love sugar for the sweetness it brings to many of their favorite baked goods. But its functionality in these products goes even further.

“Sugar can play critical functional roles, serving as a bulking agent and contributing to texture, mouthfeel, spread, structure, browning, shelf life and more,” said Dave Lindhorst, technical services manager, Cargill.

While sugar is the star of many foods, its reputation has soured in the eyes of a growing number of consumers. The rise of low-carb diets has many shoppers cutting out sugar, and growing research demonstrates a correla-

tion between high sugar intake and health complications like heart disease, obesity and diabetes.

Seventy-two percent of Americans are now trying to limit or avoid sugars, a May 2023 report from the International Food Information Council (IFIC) found, and 57% of consumers say “low in sugar” claims influence their purchasing decisions, according to a survey by ADM Outside Voice.

As a result, alternative sweeteners continue to grow in popularity, providing similar sweetness to sugar with fewer calories and carbs. But these alternatives, especially artifi-



The rise of low-carb diets has many consumers avoiding sugar.  
©Fahrrwasserstock.adobe.com

cial varieties, have come under consumer scrutiny as well.

“Artificial sweeteners suffer from a bad reputation among consumers, with many believing that artificial sugar substitutes like aspartame, sucralose and saccharin may have detrimental health effects,” observed Hank Wang, technical director, North America, Howtian.

Fifty-five percent of US consumers say “no artificial sweeteners” is an extremely or very important statement on food and beverage labels, according to the 2022 Global Trend Study from HealthFocus International, and 69% of consumers say that simple, recognizable ingredients influence their purchasing decisions, ADM’s research found.

With shoppers savvier than ever about the ingredients they consume, natural sweeteners have proven to thread the needle in providing the sweetness consumers expect in a format they’ll accept.

“The consumer gets peace of mind not only from the familiarity of the name but also the assurance that — as in the case of malt extract or molasses — these sweet-

eners have been part of the human diet for centuries,” said Joe Savelli, director of culinary innovation, Malt Products. “Natural sweeteners also shorten ingredient statements. In today’s market, shorter ingredient statements convey a message of cleaner ingredients and a cleaner, more natural finished product.”

For manufacturers looking to stay on trend by reducing or fully eliminating sugar from their products, natural sweeteners are a natural fit that fulfill consumer needs. But replacing an ingredient as critical as sugar may prove difficult, often requiring careful reformulation with multiple ingredients to get the job done.

“There are rarely simple answers when customers look to change their sweetener system,” Mr. Lindhorst said.

### **Sweetening with stevia**

Many bakers opting for an alternative sweetener turn to stevia, which has held the largest share of the natural sweetener market behind sugar for years. Approximately 200 to 400 times sweeter than sugar, stevia replaces sugar’s flavor in baked goods in smaller amounts and is more readily available on the market than other alternative sweeteners, all while being viewed more positively by consumers, said Courtney LeDrew, senior marketing manager, Cargill.

There are numerous stevia types derived from the stevia plant, and the two with the most preferred flavor profile, Reb M and Reb D, are common in baked goods. But improved stevia varieties are emerging as well.

ADM, for example, recently introduced Sweetright Stevia Edge-M, which offers improved sweetening, less bitterness and greater solubility compared to Reb M. Isolated directly from the stevia leaf as opposed to being produced through fermentation, the ingredient can be listed as a stevia leaf extract on product labels, further appealing to label-conscious consumers.

“SweetRight Stevia Edge-M also has the benefit of cost savings when compared to Reb M and Reb D,” said Sarah Diedrich, global marketing director, sweetening and texturing solutions, ADM.

Howtian similarly offers “drop-in” stevia-based solutions to match the functionality of sugar, as well as non-nutritive sweeteners and other bulking agents, said Michelle Yin, technical lead, Canada, Howtian.

Because stevia is used in small amounts, bakers will likely need to combine it with these bulking agents and additional sweeteners to provide necessary structure and a rounded taste profile to their product.

“For example, a combination of soluble corn fiber and stevia can provide the necessary bulk replacement along with the sweetness enhancement needed with stevia,” noted Justin Kanthak, director of business development for Batory Sweetener Solutions. “Other ingredients such





Emerging natural sweeteners include monk fruit and agave.

©Carl-stock.adobe.com

as allulose can provide bulk along with sweetness, at roughly 70% of the sweetness compared to sucrose.”

The Food and Drug Administration (FDA) in 2019 exempted allulose from labeling requirements for added sugars, and it has since grown in popularity. The sweetener is often combined with stevia or monk fruit as a clean label, 1-to-1 sugar replacement, Mr. Wang said.

Erythritol is another zero-calorie sweetener that pairs with stevia and other high-intensity sweeteners to provide necessary mouthfeel and bulk, Mr. Lindhorst said. On the stevia side, Cargill offers ViaTech stevia leaf extract and EverSweet stevia sweetener.

“Erythritol rounds out their sweetness profile, creating a more sugar-like sweet taste,” he said.

### Classic and cutting-edge varieties

Beyond stevia, bakers have an ever-expanding array of natural sweeteners to choose from, ranging from emerging varieties to familiar staples in consumer diets.

For example, the use of malt powders and extracts in baked goods has grown recently, Mr. Savelli noted.

“These have been used in the baking industry for a long time, but as the demand increases for baked goods that stay true to their origins, bakers are returning to using malt as a primary sweetener,” he said.

Malt enhances the flavor, texture and aroma of a variety of baked goods ranging from pizza doughs and bagels to chocolate cookies and cake, Mr. Savelli said. The company’s MaltRite Sweet, for example, offers the aroma and flavor of malted milk without dairy.

Oat extract is a sweetener rising in use thanks in part to its familiarity and clean label appeal as well.

“Its toasted flavor gives it caramel-like notes that go great in many different baking applications,” Mr. Savelli said. “It is also a great ingredient for use in vegan and plant-based baked goods, which have high appeal to consumers who enjoy oat milk.”

Honey similarly is appearing in more baked goods

due to its strong popularity among consumers. A 2021 IFIC survey found that honey is the No. 1 preferred sweetener in foods and beverages. The ingredient serves as a natural binder in nut and seed bars, and as a humectant helps keep products moist longer. Its low PH also helps inhibit some strains of bacteria growth.

“We expect honey’s popularity to continue growing as more and more consumers begin to understand the important connection that honey and honeybees have with the entire food system,” said Catherine Barry, vice president of marketing, National Honey Board.

Other lesser known but emerging sweeteners include monk fruit and agave. Monk fruit can enhance a product’s fruity or citrusy notes, Mr. Kanthak noted, and has appeared in a variety of low-sugar applications ranging from peanut butter and jelly sandwiches to snack bars.

ADM’s Sweetright Agave offers structural benefits such as binding and browning properties, moisture retention and humectancy with a neutral flavor profile and is 25% to 30% sweeter than sugar, making it an easy-to-use sugar reducer for a range of baked goods.

“Our agave checks all of the boxes consumers are looking for as both a familiar and premium ingredient on product labels,” Ms. Diedrich said.

The polyol isomalt, the only sugar replacer derived from sugar beet, may be used to reduce sugar and carbs in baked goods with half the calories of sugar. It carries a health claim from the FDA noting it doesn’t promote tooth decay and has a minimal effect on blood sugar compared to other sweeteners.

Beneo’s Palatinose can be used as a 1-to-1 replacement for sucrose or other high glycemic sugars, making it an effective ingredient for lowering the blood sugar spike caused by some baked goods.

“With its mild sugar-like sweetening profile and nutritional benefits, Palatinose is particularly popular in applications for baked goods and snacks,” said Kyle Krause, product manager, Beneo Functional Fibers and

# PURITY REIMAGINED

**PureBake®** is a modern clean label dough conditioner designed with advanced enzyme technology to give bakers more tolerance in their processing systems.



THE ART OF BAKING  
MADE SIMPLE.

## Functional properties include:

- Unrivaled process tolerance and dough stability
- Eliminates conventional emulsifiers, strengtheners and oxidizers
- A dependable dough conditioner for an ever-changing industry
- PureBake® minimizes your label, not your quality





# 100 YEARS *of...*



## SWEETENERS

Carbohydrates, North America. “Its full carbohydrate energy is provided in a balanced and sustained way without the spike and crash effect from commonly known high-glycemic carbs. Therefore, Palatinose is attractive for consumers leading an especially active lifestyle.”

Beneo also offers chicory root fibers. At 2 calories a gram, Beneo’s Orafit Inulin and Oligofructose are non-GMO and deliver digestive health benefits as a prebiotic.

“By providing bulk solids, chicory root fiber can replace sugar and added sugars while maintaining the taste and texture of the final product,” Mr. Krause said.

### Making the right adjustments

Natural sweeteners boost the appeal of baked goods in many ways, but using them to replace sugar in baked goods may pose challenges. One of the biggest obstacles bakers face is fully replicating sugar’s sweetness profile in a formulation. This is especially true in applications like cookies and cake where sugar is used in high amounts.

---

**BAKERS HAVE AN EVER-EXPANDING ARRAY OF NATURAL SWEETENERS TO CHOOSE FROM, RANGING FROM EMERGING VARIETIES TO ONES THAT HAVE BEEN STAPLES IN CONSUMER DIETS FOR DECADES.**

---

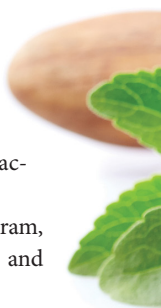
“If your ingredient swap involves using another sweetener with a lower sweetness impact, you’re going to have to account for the difference,” Mr. Lindhorst said. “Often, a high-intensity sweetener like stevia can help bridge the gap.”

Sweetness may also onset in a baked good at different times depending on the ingredient chosen, affecting which ones work best together.

“For example, stevia has a more delayed onset of sweetness compared to sugar, so you may consider complementing it with an alternative like allulose or erythritol which exhibits an earlier onset of sweetness,” Mr. Wang said.

Beyond sweetness, bakers will need to replicate the other critical functionalities sugar provides, including bulk, volume, browning and moisture retention. This may be done by combining different sweeteners in a formulation and incorporating bulking agents like fiber.

Liquid and dry sweeteners will also behave differently in a formulation and affect the moisture content of baked goods, Mr. Lindhorst noted.







Stevia is a popular sugar replacement viewed positively by many consumers.

©Dionisvera-stock.adobe.com

"If you're combining liquid and dry sweeteners, you'll need to consider the overall amount of water in the formula, as well as how the sweeteners will be incorporated together," he said. "You may need to adjust your processes to accommodate blending the dry sweetener into the liquid one."

Natural sweetener replacements may alter bake times as well, Mr. Savelli pointed out.

"Because many natural sweeteners melt easily, recipes containing these sweeteners will finish baking in a fraction of the time as their sugar-laden counterparts" he said. "Check your baked items sooner if you are using natural sweeteners to ensure they don't burn during baking."

The leavening system may also need adjusting if replacing sugar in goods where baking soda is the only leavener.

"In these types of applications, the brown sugar activates the baking soda, so you will need to be sure to add in an acidic ingredient with your natural sweetener to be sure you get the same leavening," he explained. "This can be an addition of lemon juice, yogurt, vinegar or something similar."

### **Avoiding cost and supply pains**

While there are many potential formulation challenges when replacing sugar with other natural sweeteners, cost often remains the biggest hurdle.

"With the baking industry expected to deliver affordable and accessible goods like breads and cookies, the pressure from adjacent food segments like the beverage industry can drive alternative materials above the value for return in applications," Mr. Kanthak said. "These challenges are exacerbated when considering reduced or no-sugar-added applications."

Bakers may grapple with supply issues as well, as many natural sweeteners are more difficult to source than sugar. To avoid ingredient shortages, bakers should have two suppliers of the same sweetener, Mr. Kanthak recommended.

"With many high-intensity sweeteners being produced outside of the continental United States, supply chain interruptions can not only impact delivery time but cost,"



# QUALITY *and* CONSISTENCY



*Discover the  
North Dakota Difference*

Call 1-800-538-7721 • [www.ndmill.com](http://www.ndmill.com)

FSSC 22000 CERTIFIED

NORTH  
**Dakota**  
Be Legendary.



## SWEETENERS



he said. “Flexibility and preparation can offer a little peace of mind to an ever-changing world.”

Manufacturers should also consider having a backup sweetener, especially if their current one proves to be too expensive, varies greatly in quality and is consistently unavailable, Mr. Savelli said.

“It’s also important to constantly monitor market trends, customer preferences and feedback,” he added. “If consumers start to show a strong preference for a different sweetener, it may be worth incorporating that into products.”

Thankfully for bakers, availability and cost of natural sweeteners continues to improve. Mr. Wang observed that recent expansion in stevia yield is significantly lowering the cost of these extracts.

“When coupled with the rising costs of sugar globally, we’re seeing for some of our customers that sugar

---

Natural sweeteners like molasses, oats and honey are growing in use thanks to their familiarity among consumers.

©Alp Aksoy-stock.adobe.com



## The expertise you need to perfect your products

Our Ingredient Technology & Applications (IT&A) experts will assist in helping perfect your next product. Whether you are looking to formulate a new product or reformulate your current one, utilizing our in-house expertise will expedite your projects from benchtop to production. Understanding various ingredient functionality sets us apart from other suppliers in the industry. Our technical work, together with our strategic ingredient partnerships and superior buying power, allows us to be an extension of your business.

Companies choose us because of our expertise and experience with:

- Ingredient Sourcing
- Product Development
- Packaging Claims
- Custom Blending Capabilities
- Certification Knowledge
- Matching Nutritional Requirements

**SupplySide<sup>®</sup> WEST** Booth #1821

ifpc.com | info@ifpc.com | 800.22.SUGAR



# Efficient Bun Glaze Application is Critical for Bakeries

## Market Opportunity

**Plant-based claims grew +59% in the bread category (CAGR 18-22)<sup>1</sup>**

100% plant-based claims are expected to grow strongly across bread products globally and an increased focus on sustainable manufacturing practices projected.

<sup>1</sup>Innova, 2023

## Our Solution

**Create a shiny, egg-free glaze for burger buns**

Kerry's bakery team can help you deliver a premium shiny golden glaze to buns. Kerry Bakery Glaze is available globally and does not require dilution and is stable throughout its shelf life, which eliminates the common market problem of solutions that thicken and gum up machines or stick to pans.

Our solution meets consumer demand for plant-based and improves operational efficiency and quality control on the bakery production line.



When key production factors go:

**Wrong**

Residue build up



Change in viscosity



Inconsistency in product quality



Reduced output



Increased labor costs

**Right**

Ease of application



No overspray pan residue



Increased run rates



Cost savings



Reduction in blemished buns

## Bun rejects reduced

Read our customer case study to find out how Kerry Bakery Glaze led to a combined impact of cost and labor savings and reduced food waste for a bakery manufacturer.



**VIEW CUSTOMER CASE STUDY**



## SWEETENERS



Oftentimes multiple sweeteners must be combined to fully replace sugar's functionality in a product.

©Luis Echeverri Urrea-stock.adobe.com

reduction with stevia is also translating to a cost reduction," he said.

Mr. Savelli added natural sweeteners have sourcing advantages compared to artificial ones.

"Many natural sweeteners can be obtained from multiple sources because they are less proprietary than their artificial counterparts," he explained. "This leads to markets that are relatively stable over the short and medium term."

Bakers who successfully reduce or fully replace sugar in their baked goods with natural sweeteners can capitalize on one of the leading trends in the baking industry.

"Those who have engaged in sugar reduction efforts earlier than others recognize this not just as a shift in consumer tastes, but as an emerging business and marketplace opportunity," Ms. Yin said.



## Simple Ingredients. Smart Plant-Based Solutions.

Gluten-Free | Clean-Label | Non-GMO | Grain-Free | Traditional

### Now Offering More Cassava Flour Options

**Premium Cassava Flour:** A proprietary AKFP innovation

**Multi-Purpose Cassava Flour:** General purpose gluten-free flour

**Basic Cassava Flour:** For simple gluten-free applications



**Native Potato, Tapioca, and Pea Starches:** Excellent for thickening and binding, and for gluten-free baked goods.

**Waxy Tapioca Starch:** Good emulsifier; enhances expansion, crispiness, mouthfeel.

**Premium Cassava Dough Blend:** Versatile clean-label, gluten-free starch blend.

**Kumamoto Superfine Rice Flours:** Specially milled for superior gluten-free baked goods.



American Key Food Products, 1 Reuten Drive, Closter, NJ 07624 | Toll-free: (877) 263-7539



[www.akfponline.com/BNS](http://www.akfponline.com/BNS)





# Life is Short, Kake Mate™ is Easy

Our Kake Mate™ emulsifier allows you to create consistent high-quality cakes that are taller, lighter, and bake more evenly – all day, every day.

- Superior operational tolerance
- Improves cycle time
- Extends shelf life

To learn more, contact us at: [Info.food@vantagegrp.com](mailto:Info.food@vantagegrp.com)

Our integrated approach includes industry experts, processing ingredients, and precision spray equipment that help increase operational efficiency and your peace of mind.

Better Cakes  
Made Possible







**Add flavor, color and character  
with Flav-R-Bites™**



**Add a crunchy, delicious texture  
with our clusters!**



## **Ingredient Heat Treatment Processing**

Our thermal process will significantly  
reduce pathogens to an acceptable  
level in your ingredients.



4720 South 13th Street, Leavenworth, KS 66048 • Phone: 913-727-3434  
3001 Eastowne Drive, St. Joseph, MO 64507  
[www.ciifoods.com](http://www.ciifoods.com)



# packed with Protein

Consumers want baked goods, and bakers have many options to fill that need.

by Donna Berry

Stephen Charles Lincoln, creator of New York City's The Protein Bakery, believes that everyone deserves a cookie, just one that's a little healthier for them than most. That's why he makes whey protein concentrate — a high-quality, complete protein known for its muscle-building properties — the star of his products, which include blondies, brownies and cookies.

"Protein makes you feel fuller faster and prevents spikes in blood-sugar levels," Mr. Lincoln said. "It's a sure way to keep the heartbeat steady and the body in balance."

Proteins also provide functionality to baked goods. The goal is to achieve that perfect balance between nutrition and function and still deliver on taste, texture and shelf life.

"Many proteins can provide excellent benefits in baked goods, like structure, gelation, increased browning, loaf

volume, improved moistness and texture," said Jason Demmerly, senior director, research and development, Glanbia Nutritionals.

## Marketing nutrient density

For a growing number of consumers, smart snacks translate to those higher in protein and lower in added sugars. In fact, protein is the No. 1 nutrient Americans said they are seeking to consume, according to the 2023 Food and Health Survey from the International Food Information Council, Washington, DC.

Bakers looking to attract these shoppers are including all types of proteins in new product development, often combining a variety of plant and animal sources that deliver the highest protein content possible without sacrificing quality.

Protein can be added to bars in several ways, including coatings, inclusions and toppings.

©Happy\_lark-stock.adobe.com





"I chose the name Protein Bakery for a good and healthy reason," Mr. Lincoln said of his bakery, founded in 1999. "It's to emphasize our unique muscle-building whey protein concentrate that is richer, better-tasting and a huge component in all our baked goods."

Indeed, dairy proteins are high-quality, complete proteins, meaning they contain the necessary amounts of all the essential amino acids required by the human body to function at its best.

Eggs are another complete source of protein that are clean label, nutritious and are in the refrigerator of nearly every home in the United States, said Elisa Maloberti, manager of special projects and food safety with the American Egg Board. She also stressed how multifunctional eggs are in baked goods.

"If you take eggs out, then you have to replace them with other ingredients and sometimes with multiple ingredients," she said.

Eggs offer many attributes to baked foods including flavor, color, emulsification, binding, crumb structure and more. However, if bakers want to really increase the level of protein in products, they would likely need to turn to other proteins.

"In many cases, you would add other sources of protein to that product," said Nelson Serrano-Bahri, director of innovation with the American Egg Board. "And the reason for that is because of the functionality of eggs. As we con-

tinue to add eggs outside the boundaries of functionality within a formula, you start getting undesirable textures. So you would keep that functionality and add other sources of protein in order to raise the amount of protein."

Kind LLC, New York City, a subsidiary of Mars Inc., McLean, Va., has been finding success with its Breakfast Protein Bars, marketed as "sustained energy from 100% whole grains." Five grains — oats, buckwheat, millet, amaranth and quinoa — in the new caramel peanut variety contribute to the 8 grams of protein per bar. Other sources of plant protein include peanut butter and soy protein isolate.

Soy is one of the few plant proteins that is considered complete. Others include chia and hemp seeds, pistachios and quinoa. But the use of plant proteins in baked goods is limited because of their impact on taste and texture.

"In addition to nutritional benefits, using blends of two or more proteins can help manage off notes," said Dave Lindhorst, technical services manager, Cargill.

Lenny & Larry's, Los Angeles, now includes dairy proteins in some of its products. The company was founded in 1993 by two bodybuilders who decided to make cookies a better-for-you snack by loading them up with plant protein. Lenny & Larry's now offers The Boss! bars and cookies with dairy proteins, which contain more than double the protein of the original vegan cookies. The formulation relies on a blend of hydrolyzed milk protein isolate, milk protein isolate and wheat protein isolate that deliver 18 grams of protein per 2-oz cookie.

"Wheat protein isolates are used to achieve protein content claims and are essential ingredients for low net-carb formulations along with dietary fiber sources," said Tanya Jeradechachai, vice president of research and development, MGP Ingredients. "They are highly functional and can enhance dough processing, water absorption and overall baked product quality. In addition, wheat protein isolates can increase shelf life in flour tortillas, partially replace eggs in chemically leavened products, reduce fat absorption in cake donuts and replace chemical reducing agents/dough relaxers and enzymes typically used in commercial bakery production."

Wheat protein isolate is essential to Los Angeles-based BetterBrand's baked goods. The company is debuting low-carb, high-protein buns in brioche, pretzel and sesame varieties. The launch follows the recent expan-

Whey offers bakers a complete protein to add to their bakery formulations.  
The Protein Bakery



# BAKERS

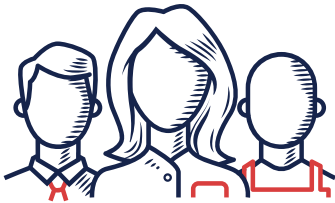
FLY-IN AND POLICY SUMMIT



*Retail  
Bakers of  
America*



NOVEMBER 13-15, 2023 | WASHINGTON, DC



## CONNECT

Reignite and develop relationships with a community of baking industry professionals, policy experts, and peers from ABA, RBA, and ASB.



## LEARN

Hear from agency officials, panels of business association experts, and keynote addresses from policymakers to learn about the central issues affecting the baking industry, and how your voice can make an impact.



## ADVOCATE

With guidance and assistance from ABA's advocacy experts, share our industry's unique perspective and challenges in small group meetings with key lawmakers on Capitol Hill and help educate them and their staff on our policy priorities.



**Register Now**  
[AmericanBakers.org/Events](https://AmericanBakers.org/Events)



## WHEN FORMULATING BAKED GOODS WITH PROTEIN, MANAGING WATER CONTENT IS PARAMOUNT.

sion of the company's original concept, The Better Bagel. Pretzel and Sesame have joined the Original flavor.

### Balancing nutrition with functionality

When formulating baked goods with protein, managing water content is paramount because proteins bind water.

"There are several inherent challenges when trying to fortify baked goods with high levels of protein," Mr. Demmerly said. "Proteins compete for water, and this can affect dough hydration. It's important to understand the varying degrees of moisture absorption of these ingredients compared to flour. There are also several limitations due to the interactions between proteins and starches in the system, which can lead to reduced viscosity and pasting properties as well as lower setback values."

But these issues should not deter bakers from working with proteins. They do more than boost nutrition profiles. Further, some baked goods are more forgiving than others toward higher protein content. Soft-baked cookies, for example, have low-water content, making it easier to increase their protein and avoid negative ingredient interactions.

"When trying to counter absorption issues in a bakery product, we advise product developers to look at their entire formula," said Aaron Reed, senior food technologist, Cargill. "The key is balancing high water-absorbing ingredients with plasticizing (low-absorbing) ingredients. For example, bakers may need to add more sugar and fat to offset the water absorption of the proteins or use more proteins that have plasticizing properties."

Vital wheat gluten is also an important contributor when addressing absorption challenges.

"Vital wheat gluten is a superhero when it comes to baked goods, with strength, elasticity and binding properties among its many superpowers," Mr. Lindhorst said. "It's best known for its contributions to breads, where it aids in mixing, dough handling, loaf volume and finished prod-

*Bringing You Our Best*



*There is a Mennel difference.  
Partner with us and see for yourself.*

**Mennel**

Trusted since 1886

Grain | Flour | Bakery Mix | Transportation





Nuts, seeds and flours made from ancient grains, beans and pulses contribute nutrition and functionality to recipes.

©Forma-stock.adobe.com

uct quality. But it can also help meet nutritional goals, with 75% protein on a dry-matter basis. Pea protein is another good candidate for bakery products. Paired with a complementary protein source such as rice, wheat gluten or soy, it's easy to achieve a complete protein claim. Functionally, pea protein can also help with moisture retention."

Wheat proteins work well when trying to balance both nutrition claims and product quality because of their functionality and clean taste profile, said Brook Carson, vice president, research and development, Manildra Group USA. The company's wide range of wheat proteins can provide different functionalities depending on whether a bakery application needs elasticity, extensibility or solubility.

GemPro HPG, for example, yields 90% protein with a high degree of water absorption and viscoelastic properties that enable bakers to improve volume in weaker doughs. The GemPro Nova line contains 85% protein and is designed to replace eggs by delivering on the same aeration and emulsification capabilities in different bakery applications.

"Wheat proteins already have that natural wheat flavor while also being able to help bakers achieve the texture they want as they add protein to their formulations," Ms. Carson explained.

Pea and wheat protein blends are trending in the plant protein-forward baked savory and sweet snacks space. By combining plant proteins, a more balanced amino acid profile is possible, which improves the overall pro-



## CREATIVE BAKERY SOLUTIONS

*Laminated Pizza*



CLEAN  
LABEL

NON-GMO

ORGANIC

VEGAN

ALLERGEN  
FREE

KETO



- Pizza Bases & Mixes
- Pizza Dough Conditioners
- Shelf Life Extenders

- Ingredient Replacers
- Natural Flavors & Inclusions

EUROGERM KB LLC | Ph: 847.221.5004 | [www.eurogerm-kb.com](http://www.eurogerm-kb.com)



## PROTEIN



tein quality of the snack and makes it more appealing.

“The protein blends can be used in tandem with texture and functional solutions, including clean-tasting soy crisps made from soy protein isolate, to help create delicious protein-forward baked goods and snacks,” said Jeff Hodges, manager, bakery, snacks and confections applications, ADM. “Pea proteins have overall low total aromatics, including less beany, earthy and bitter notes. They also can support clean label targets as they are inherently non-GMO.”

### Distributing protein in a formulation

The beauty of many baked goods is that they are composed of multiple items, such as coatings, fillings, inclusions and more. Protein can be included in most components.

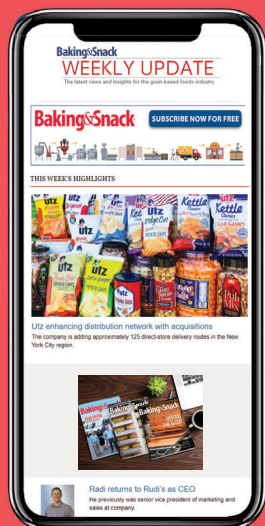
David Guilfoyle, design manager bakery/fats and oils, IFF, noted that distributing the protein throughout the product design will help to maintain great texture, flavor

Several items can contribute protein in baked goods. The dough of a jelly donut and the jelly itself can get a protein boost.

©Brent Hofacker-stock.adobe.com

Baking&Snack

# Make Smarter Decisions



### ALL THE NEWS YOU NEED TO STAY INFORMED.

The *Baking & Snack Weekly Update* newsletter delivers timely news and analysis of the grain-based foods industry directly to your inbox.



Subscribe to the free  
*Baking & Snack Weekly Update* newsletter

Sign up at  
[bakingbusiness.com/newsletter\\_subscriptions](http://bakingbusiness.com/newsletter_subscriptions)

**SOSLAND**  
PUBLISHING





# TOASTING MAKES EVERYTHING BETTER

Consumers crave texture. Give it to them with clean-label toasted grains from DakotaMB. Our custom and standard toasted grains, including barley, oats, rye, spelt, triticale, and wheat, are designed to enhance texture, flavor and visual appeal in a variety of applications.

**Granola:** Custom and standard toasted granola made with a blend of whole rolled oats, toasted wheat flakes and brown sugar or honey.

**Crunch Toppings:** Toasted topping blends that add texture to donuts, cakes and other bakery foods.

**DakotaMB is your  
experienced partner for all  
your toasted grain needs.**



**DAKOTAMB**

[DakotaMB.com](http://DakotaMB.com)







Whole grains power the protein content for several baked products.

KIND LLC.

nutritional bars, snacks and cereal applications. The line includes hemp and pea crisps for protein enhancement, and crisps made with alternative botanicals and ancient grains.

"They come in multiple shapes and offer consumer-friendly attributes, including gluten-free, clean label and organic," Ms. Jeradechachai said.

With assistance from emulsifiers and hydrocolloids, all types of baked goods can be designed with protein-enriched elements. Even an iced jelly-filled donut offers

and appearance for better overall quality. For example, to add protein to a coated oatmeal and fruit cookie bar, protein powder and protein nuggets can be added.

"The high-protein nuggets have more than 90% protein, which enables high-protein bars with crunchy texture and helps with the shelf life," he said.

MGP Ingredients has new plant-based protein crisp inclusions, which may be used for texture and crunch in

opportunities for protein fortification in a few ways.

"Pea protein can be added to the donut dough, along with a protein masker to improve the flavor of the donut," Mr. Guilfoyle said. "Pea protein-fortified jelly can be injected into the finished donut. The donut can also have pea-protein fortified fruit paste pieces with chia seed inclusions to layer in textural and flavor enhancements. The emulsifiers and hydrocolloids will help with increasing the moisture retention within the product, which in turn also aids in shelf life extension and better mouthfeel."

The addition of protein-containing ingredients, such as nuts, seeds and flours made from ancient grains, beans and pulses, also contributes nutrition and functionality to recipes. Many will provide visual appeal and layers of texture.

"These wholesome ingredients add nutritional attributes, offering protein, fiber, potassium and iron," Mr. Hodges said.

Consumers are clearly seeking out quality protein-packed products, and bakers have several options to create them. Exploring all of the options will help them find the best formulations for their products.



## Oil Experts, Loyal Partners

From custom oil blends to innovate new products, to the right oils for all your culinary creations, when you get to know CVO, you get access to oil experts who take the time to get to know exactly what you need.

**GET TO KNOW CVO**



Visit us at [cvoils.com](http://cvoils.com) or contact a sales representative at [sales@cvoils.com](mailto:sales@cvoils.com)







# PUT YOUR TORTILLAS ON TOP!

## OUR INNOVATIVE BATCHPAK™ SYSTEMS ASSURE SUPERIOR PRODUCTS EVERY TIME – PERIOD.

Our custom and pre-blended BatchPak™ formulations have been developed in our state-of-the-art Tortilla Innovation Center to achieve taste, consistency and shelf life superiority. They also reduce the variables that cause error and yield loss. Now available in all the tortilla varieties consumers demand, including:

- Gluten Free
- Clean Label
- Multigrain
- Non-GMO
- Low Sodium
- Low Carb
- Low Fat
- Heart Healthy
- Organic
- Fluffy White Gordita

**Create on-trend tortillas with BatchPak™ Systems.  
Contact your Allied Blending representative today.**



Proud member of T.I.A.





# The world's best foods are made on the world's best equipment.

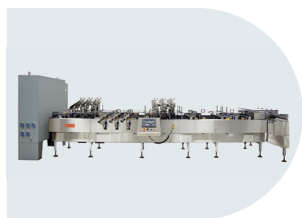
Since 1913, businesses like yours have relied on Peerless equipment to create delicious food efficiently, consistently — and above all, dependably. You need equipment and a partner you can count on. You need Peerless equipment.

Engineered and built for the great results you want and the productivity you need — year after year



## Peerless mixers

Unmatched performance, reliability and productivity. Custom built to your specifications with an extensive range of available options.



## Peters sandwiching/ biscuit creamers

Versatile, high-performance machines that accommodate a wide range of base cakes and fillings to create sandwich cookies like no other.



## Creams and batters equipment

Ensure fast, accurate production with exceptional quality, from the first mix of the batter to the final coated product.



## Customer service and parts team

Dedicated to providing the highest level of reliability and responsiveness to keep your operations running smoothly and efficiently.

.....  
follow us on



SCAN TO VISIT  
OUR WEBSITE

## Peerless Food Equipment

500 S. Vandemark Road, Sidney, OH 45365-0769 USA  
☎ (937) 492-4158, (877) 795-7377 | 🌐 [peerlessfood.com](http://peerlessfood.com)



**PEERLESS**  
FOOD EQUIPMENT



# empowered to INNOVATE

Innovation is kicking up, and snack manufacturers need flexible lines to get their new products off the ground.

by Charlotte Atchley

The snack category is one bursting with new products. This popularity and growth inspire manufacturers to constantly turn out new products to entice consumers. Trends like indulgence and better-for-you (BFY) are at the center of much of this growth as consumers turn to snacks to satiate a variety of needs: emotional rewards, meal replacement and exposure to new flavors.

It's important to note, however, that when it comes to BFY snacks, the definition of healthy includes a plethora of attributes. Reduced sugar as well as sodium and calorie control are still relevant, but the definition has expanded. Value-added snacks that pack extra protein and fiber exist in the space next to snacks with clean ingredient lists. Gluten-free and keto-friendly have become mainstream claims. All of these formulations add complexity not just in the R&D lab, but also on the production floor. From snack forming to seasoning, ingredients like pulses, protein and fiber bring new challenges to processing puffs, pretzels and other extruded snacks.

"The push for better-for-you snacks has increased the amount of dough that needs to be processed slightly differently, but it can perform just as well in extruders with some adjustments," said Nico Roesler, North American pretzel and snack equipment sales manager, Reading

Bakery Systems (RBS). "At our technical center, we've worked with customers that use gluten-free formulations that feature many new and innovative starches and proteins. These doughs all behave differently based on their protein structures, but with various modifications and pre-feed systems, these better-for-you doughs can process similar to a typical wheat-based dough."

All it takes is understanding the dough's performance needs and adapting the equipment, from extrusion to seasoning, to meet those requirements consistently.

## Challenges with alternatives

BFY snacks come in a variety of forms made with many different ingredients, all of which impact extrusion. When increasing protein levels, snack manufacturers often rely on starches, protein powders, soy flours, chickpeas and even whey proteins.

"Nowadays, starch-based snacks are often enriched with fibers and proteins," said Christian Hüttner, process engineer, food extrusion, Coperion GmbH. "This can have a major impact on the expansion characteristics, such as size and shape porosity, in the manufacturing process. If raw materials with high-moisture content like slurries from fresh fruits or vegetables or raw materials

For low-pressure extrusion, alternative ingredients can require more mechanical force to avoid any gaps in the dough as it's fed through the extruder.

Reading Bakery Systems





Fast-moving, innovative snack producers are looking for equipment offering quick, tool-less removal of attachments to move quickly from one product to the next.

Reiser

with high-fat content are used, it is a challenge to introduce enough mechanical and thermal energy into the extrusion process.”

Mike Shaw, sales account manager, snacks/cereals, Bühler Inc., noted that while healthy ingredients may require some changes to the equipment, most can easily run on twin-screw extruders.

“Some high-protein ingredients with fine granulation may require consideration for direct feeding to the extruder infeed to guarantee consistent flow,” he said. “The addition of protein and fiber can also hinder expansion in the end product, so the screw configuration must be tailored to the type of protein and quantity in the formulation.”

## TO KEEP INCLUSIONS INTACT, EXTRUDERS NEED TO BE GENTLE TO MOVE THEM THROUGH THE PROCESS WITHOUT DAMAGING THEM.

Both high-protein and high-fiber snacks will have an impact on texture, a direct result of the changes to the product expansion profile as the dough is pushed and cooked through high-pressure extrusion. These products also often require more mechanical energy to achieve the desired mouthfeel, explained José Coelho, president, Clextal USA.

“The more fiber and protein we add, the lower the rate of product expansion; the product bite tends to be harder and the product surface rougher,” he said. “This is not necessarily a negative consequence, depending on the product desired.”

Flexibility and parameter control are critical to addressing most of these challenges. Clextal’s Evolum+ platform provides a greater range of mechanical energy and screw speeds during processing.

“This lets us increase the mechanical energy to modify the internal product texture,” Mr. Coelho said. “When we process at higher speeds, we can obtain finer internal texture and lower density in the snacks.”

The process section of Coperion’s ZSK Food Extruder contains several barrels in which the co-rotating screws operate.

“The closely intermeshing screws with their tight self-wiping profile eliminate stagnant zones over the whole length of the process section,” Mr. Hüttner explained.

Coperion’s extruder also combines high-free screw volume, screw speeds up to 1,800 min<sup>-1</sup> and a specific torque of 11.3 Nm/cm<sup>3</sup>. This combination allows the extruder to be configured for every application, especially high-feed intake of those raw materials that have a low bulk density, often those that have a BFY health halo.

Sticky doughs can get stuck inside the extruder and prevent product from flowing evenly. In those situations, Paul W. Hill, national bakery sales manager, Handtmann Canada, recommended feed systems that are designed to reduce friction and feature short paths.

“Material selection for the feed system is also part of the reduced friction design process, and specialized coatings can also be used to reduce the coefficient of friction,” he said. “Water-jacketed temperature control has also been very helpful in managing things like the product flow of fudge on extruded baked products without valve-free depositing systems, for instance.”

When it comes to low-pressure extruded snacks, Mr. Roesler said much of the challenge BFY doughs pose can be addressed with simple modifications.

“Gluten-free doughs, for example, are missing the elasticity and strength of wheat-based snacks, so the dough doesn’t fill the extruder chamber as easily,” he said.

This can cause gaps as the dough isn’t pulled evenly into the extruder. Those gaps impact the even pressure necessary throughout the extruder and can cause inaccurate, inconsistent piece weights. A pre-feed system attached to the front of the extruder forces the gluten-free doughs into the extruder evenly, avoiding these issues.

“Without a pre-feed system, the dough will sit on top of the screws inside the extruder and won’t get pulled in,” Mr. Roesler explained. “That creates bridging, or air pockets. The pre-feed system mechanically forces it into the chamber and eliminates the bridging.”

He did recommend snack manufacturers stick to fine flours, however, that create a homogenous dough. Low-pressure extrusion does not lend itself well to inclusions,



# Engineered to outbake the competition.

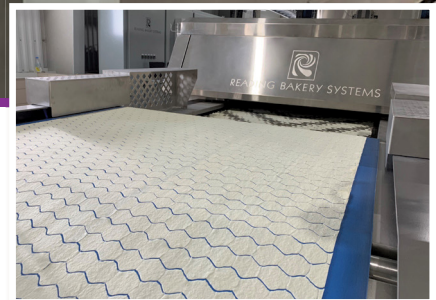
Sustainable oven solutions from Reading Bakery Systems.



## Put our latest advancements in baking technology to work for you.

Reading Bakery Systems ovens feature advanced technology that delivers the flexibility, consistency, and efficiency you need to perfect your process and your products. Our oven engineering team employs sustainable and sanitary design principles, energy-efficient materials, as well as valuable data gathered by our exclusive SCORPION® 2 Profiling System to optimize production. RBS outbakes the competition, so you can too.

- **Reduce carbon footprint** with alternative fuel and electric ovens.
- **Reduce energy costs** with better insulation, stack heat reclamation, lighter oven belts, and recipe-driven baking profiles.
- **Improve product quality and efficiency** using hybrid ovens.
- **Increase product output** with better baking technology.
- **Reduce sanitation time** with SafeShield® design protocols.
- **Increase operational sustainability** with fully automated controls.



READING  
BAKERY  
SYSTEMS

A Markel Food Group Company



September 11–13, 2023  
Las Vegas Convention Center  
Las Vegas, Nevada USA

VISIT RBS.  
Booth LU-7404.

For more information, call (01) 610-693-5816  
or visit [readingbakery.com](http://readingbakery.com).



which can get stuck and damage the extrusion nozzles in addition to affecting cuttability and piece weight. In the instance of using inclusions for low-pressure extruded snacks, Mr. Roesler said RBS will often recommend snack manufacturers use them as toppings instead, adding them after extrusion and before baking.

Inclusions can play a role in new snack development as companies try to give consumers visible signs of nutrition through ingredients like nuts and seeds.

“Extruded healthy snacks usually mean more fiber and protein with less sugar, and these healthy snacks can be some of the harder materials that run through our extruders,” said John Giacoio, vice president, sales and marketing, Rheon USA. “Many times, it also means these snacks have large particulates, giving the final product more of a value-added appearance.”

Inclusions, however, pose some challenges to extrusion. They make doughs more difficult to process and need to remain intact to provide the payoff of visibility.

“We have been seeing products that are increasingly difficult to scale and form,” said John McIsaac, vice president of strategic business development, Reiser. “Products are stiff doughs with large inclusions, but our Vemag is typically able to handle them.”

To keep inclusions intact, extruders need to be gentle to move them through the process without damaging them.

“This is where Rheon co-extruders shine,” Mr. Giacoio

said. “Not only are our co-extruders gentle in how we handle particulates, but we can also add a filling such as a nut butter.”

Fillings provide snack producers another opportunity to provide more nutritional value to consumers as well as position the products as premium.

“When manufacturers find out they can also add a filling, it turns out to be a game changer,” Mr. Giacoio said. “Being able to make a filled healthy snack allows manufacturers to separate materials, showing a clear filling instead of just mixing everything together. It eats and looks like a high-end product.”

If fillings are encased, however, in a BFY dough, Mr. Roesler said it’s critical that the dough jacket is formulated with the strength to seal the filling without cracks or leaks. Not only does this ensure the quality and integrity of the snack, but it also is a matter of safety.

“In formulating these products, the filling needs to be bake-stable, and that means modifying the oil content so the oil doesn’t leak out during baking,” he said. “Not only does this create inconsistent pieces, but it also creates a fire hazard as the oil can leak onto a hot oven belt and can be difficult to clean off.”

### Precision seasoning

Once snacks are created — whether in a high-pressure extruder that cooks the material, a low-pressure extruder before a fryer or oven, or a co-extruder — they come to the seasoning systems. Seasoning plays a critical role in differentiating snacks from the competition. This section lets snack manufacturers get creative in product development, so it’s imperative that these systems provide an even coating that adheres to the snack.

“Producing a consistent, evenly coated finished product requires several design features working together,” said Tim Nanney, technical sales manager, North America, Heat and Control. “The flow of uncoated base product that goes into the coating drum should be metered. The product should have sufficient dwell time within the drum, and the properly configured liquid and dry application equipment should be coordinated with the other parts to create a uniform finished coated product.”

The coating drums for seasoning snacks are engineered based on product throughput, bulk density and the shape and size of the product. Mr. Nanney said a properly designed coating drum should gently lift and fold the product, exposing each piece to the product bed repeatedly for both the liquid and dry seasoning applications.

“Within the coating drum, proper design and placement of liquid and dry ingredient application equipment are also important,” he said. “To achieve this with

Different nozzle attachments allow snack producers to alter their piece shapes quickly, giving them more versatility in product range.

Handtmann







**2023**  
Oct 22 - 26  
Munich

BOOTH 111, HALL A2



# Big output in the smallest of spaces.

*Brand new bread line!*

With PROGRESSA bread, process pre-proofed doughs and doughs with a high rye or water content of the same quality as a large-scale line. Contact our Bakery Team to learn more at 800-800-8552.



**FRITSCH**





Precise control of parameters on extruders like screw feed allows snack manufacturers to incorporate alternative ingredients like pulses into their snack processing.

Coperion GmbH

the liquid ingredients, the Spray Dynamics Soft Flight coating drum uses a multi-nozzle spray bar. A curtain of seasoning produced by a vibratory scarf plate is used to apply dry ingredients. The two-zone AccuFlavor tumble drum uses a two-stage system which doubles dwell time and provides consistent flow through the seasoning curtain over various throughputs.”

When it comes to whole grain and gluten-free snacks, Blake Svejksky, general manager, product handling systems, Heat and Control, said they often see snack manufacturers adding more seasoning to their products. This requires them to increase the amount of applied oil that serves as the bonding agent.

“In some applications, oil and dry seasoning are blended and applied as a slurry,” he said. “Some slurry-coated snacks also received a dry seasoning after the slurry to add further taste and texture to the product.”

When it comes to BFY snacks, precision is critical as well on the seasoning side.

“To remain healthy, snacks that have a whole grain, gluten-free or fruit and vegetable base require exact quantities of fluid to be applied to ensure the seasoning adheres to the snack,” said Elwyn Cope, group solution specialist, seasoning and spraying, TNA solutions.

TNA’s intelli-flav OMS 5.1 uses a mass-based gravimetric spraying and dry seasoning control method to ensure the exact amount of seasoning or oil is applied based on the pre-programmed recipe. The system’s monitoring software and controls collect data across the seasoning process. By doing this the intelli-flav OMS 5.1 can detect irregularities and adjust accordingly.

“The system is able to maintain an accurate control of product, oil spray and seasoning powder flow and combined with its responsive variable mass seasoning system, ensures consistent and even flavor dispersion,” Mr. Cope said.

Computer controls allow for precision application, but they can also keep production moving throughout.

“Burford Corp. uses computer-controlled dispense rates and an easy-to-use interface to allow output adjustment if desired without interrupting product flow,” said Josh Hughes, group marketing coordinator, Burford Corp., a Middleby Bakery company. “The addition of servo-controlled dispensing can add another level of precision and speed to the application of seasonings.”

The spraying system can also help with seasoning adhesion by lightly misting snack pieces with the appropriate amount of water necessary to provide the correct amount of adhesion assistance.

### Developing flexibility

In the snack category, flexibility is the name of the game when it comes to processing.

“Innovation is key in the snack market, so snack makers need flexible equipment to make different varieties of snacks or even completely new products without the need for capital expenditures,” Mr. Coelho said. “Extruders offer this flexibility, combined with versatility to run different products on the same production line, giving processors the ability to make new products or line extensions, and quickly scale to full production.”

This is especially true for smaller snack manufacturers, who are often those working with the latest, trendiest ingredients and developing new product lines all the time hoping to break through the noise of mainstream producers.

“We see lots of activity with smaller producers who want to expand their product lines,” Mr. McIsaac said. “Our challenge is to make their machinery multipurpose. The same machine that forms and portions a high protein cookie must also be able to produce bars or fill tubs. Bakers can add our new tunnel rounders to also produce bite-size balls of product.”

The flexibility of twin-screw extruders make them well-suited for direct expanded snacks made with alternative ingredients, Mr. Shaw noted, especially as those products begin to overlap into new formats as well.

“The market trend to create hybrid products between snacks and crackers is also well-suited for the extrusion platform due to the wide range of possible process parameter adjustments and ancillary set-up. The screw pushout device on Bühler twin-screw extruders ensures that changeover from shutdowns is as fast as possible.”

When it comes to using the latest ingredients, much of the flexibility that aids innovation also addresses some of the challenges that come with alternative bases. Extruders designed with flexibility have the capability to



# SSV Series Drum Motor

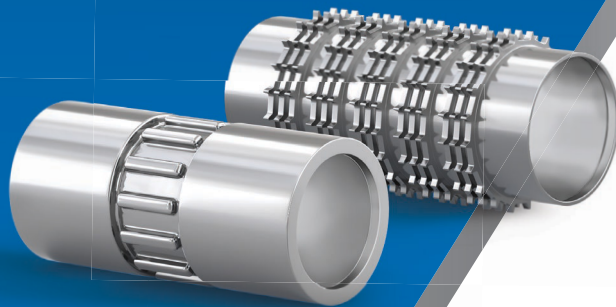
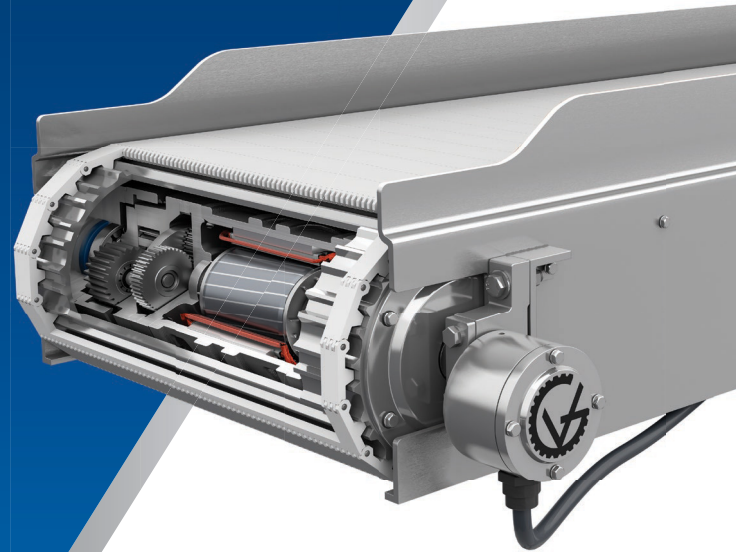
The Most Hygienic Conveyor Belt Drive



SSV Drum Motors drive modular conveyor belts without using sprockets, eliminate gaps and crevices, and reduce washdown time and water usage by 50%.

Designed for 80,000 hours of continuous operation before maintenance, SSV Drum Motors increase throughput and reduce operational costs.

- ▶ IP69K Sealing System
- ▶ Washdown Up to 3,000 psi



Scan to  
watch video

- ELIMINATE** Drive Sprockets
- ELIMINATE** Product Build-Up
- ELIMINATE** Bacterial Harborage

The new patented **SSV-XP** Drum Motor features an interchangeable profiled sleeve that can be removed and exchanged for another profiled sleeve to match the belt required on the conveyor without changing the drum motor.



[www.vandergraaf.com/BK](http://www.vandergraaf.com/BK) • (888) 326-1476



# IN THE SNACK CATEGORY, FLEXIBILITY IS THE NAME OF THE GAME WHEN IT COMES TO PROCESSING.

offer a precise level of control over parameters.

“When working with different raw materials and blends, you need equipment with the ability to generate the precise level of thermo-mechanical cooking to achieve the desired snack structure and product density,” Mr. Coehlo said. “These two elements are linked as they dictate the mouthfeel and crunchiness level. ... The twin-screw extruder is a very versatile processing tool with almost unlimited parameter adjustments, and we rely on our expertise to find the right combination to reach our customers’ product goals.”

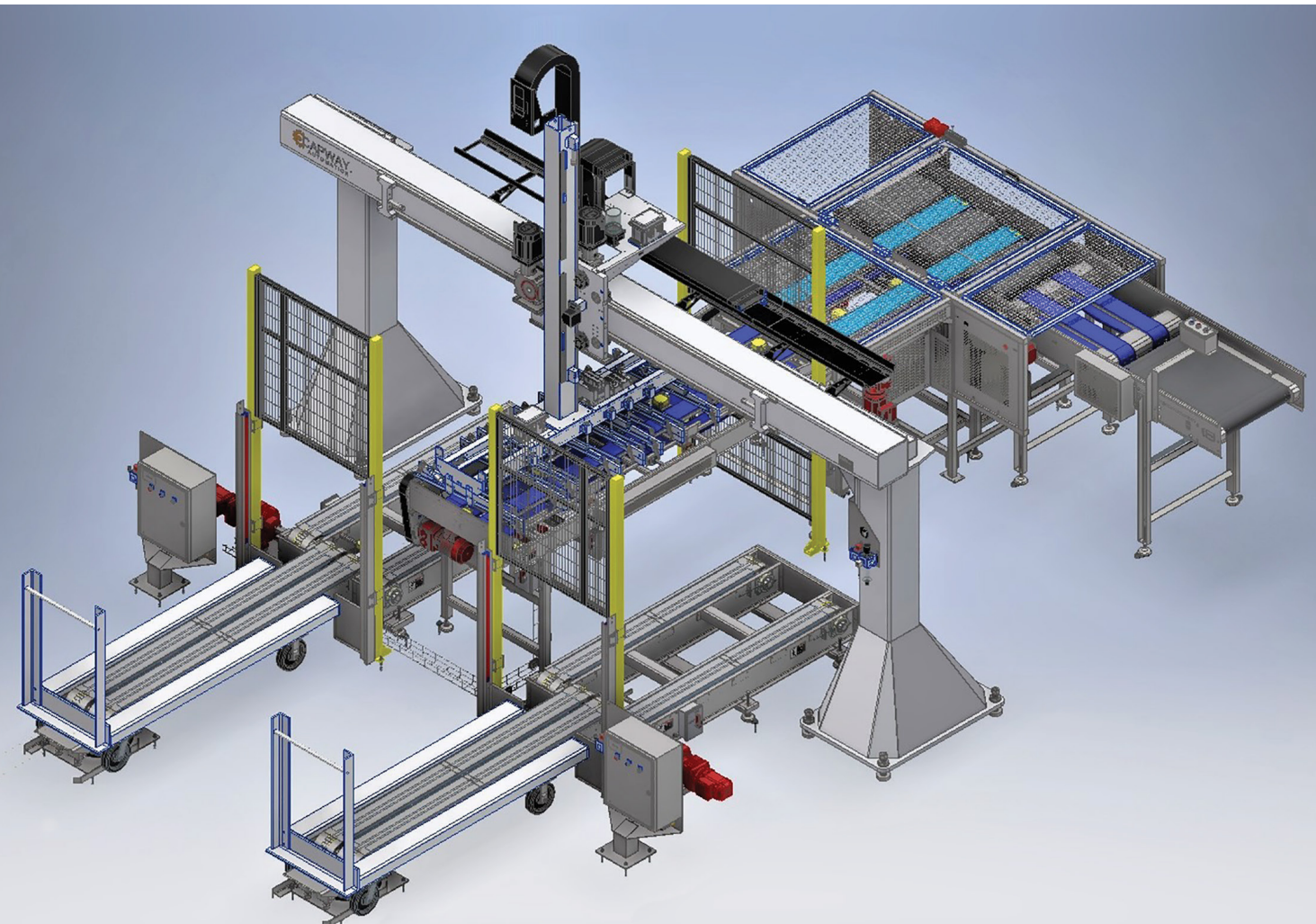
As Mr. Hüttner pointed out, alternative snack ingre-

dients require different levels of mechanical energy and screw speeds in order to process through the extruder correctly. Being able to adjust to those needs quickly is critical for snack manufacturers to extrude a snack piece that will be the proper weight and texture. Coperion’s ZSK Mv Plus Food Extruder can incorporate different capabilities to adapt.

“The addition of steam directly into the extruder’s process section as well as the possibility of high screw speeds allows the extruder to produce all the necessary energy so that no preconditioner is needed,” he said. “Intensive degassing possibilities help get rid of excess moisture so that even raw materials with a high moisture content can be processed.”

The ZSK Food Extruder can be individually configured to meet a snack’s processing challenges due to its modular design and the combination of free-screw volume, screw speed and torque, Ms. Hüttner explained.

In addition to adjusting to a snack’s different processing parameters, the machine itself needs to be able to swap out tooling, pre-feeders and other accessories





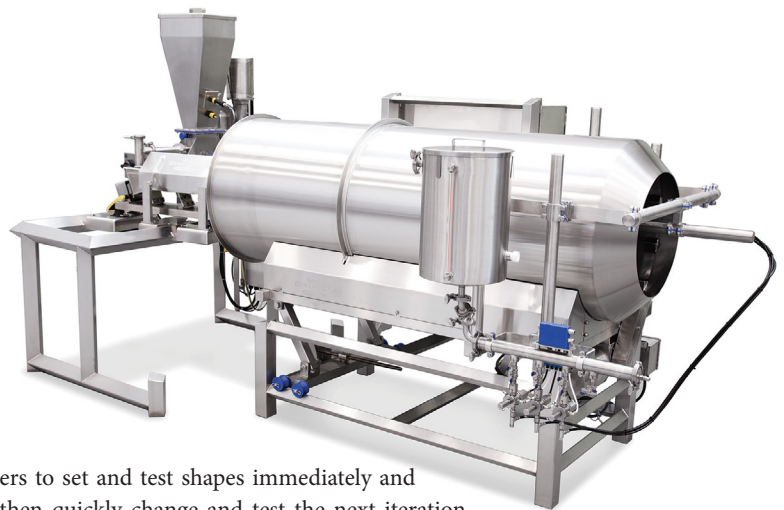
quickly and easily to enable flexible processing.

"Coperion equips the ZSK Food Extruder with numerous features that speed up changeovers of recipes and ingredients," Mr. Hüttner said. "Feed hoppers, degassing domes and atmospheric ventings are equipped with quick-release clamps."

Even a co-extruder with its added complexity needs to be able to make a quick change. Rheon designed its co-extruders to feature five main assemblies that can be added or removed from the machine in just a few minutes.

"These assemblies are the only parts of the machine that come in contact with the food product, so cleaning of the main machine body is not necessary during a changeover," Mr. Giacoio said. "These assemblies need to be washed and reassembled, but we can also offer duplicate assemblies that can be used on the machine while the other parts are being cleaned."

When it comes to innovating new products, Handtmann features real-time 3D shape design through its control panel. This feature allows snack manufactur-



ers to set and test shapes immediately and then quickly change and test the next iteration.

The Handtmann VF can quickly change configurations for different lanes and attachments as well as a variety of dough viscosities.

"The flexibility and rapid set up of Handtmann coextrusion solutions also offers new product development opportunities that allow simplified R&D and high-volume production with very accurate outer and inner coextruded weights that dramatically reduce giveaway," Mr. Hill explained.

Reiser aims to design its changeovers to be as tool-less

Properly designed seasoning drums enable a consistent, even coat of seasoning on all snack pieces.

Heat and Control

## We're baking up something new!

### RoboStack: The next generation of robotic pan stacking

We're putting the finishing touches on Capway's latest innovation in bakery automation. RoboStack ensures the smooth transition of pans as they leave the production line.

RoboStack is designed and built to:

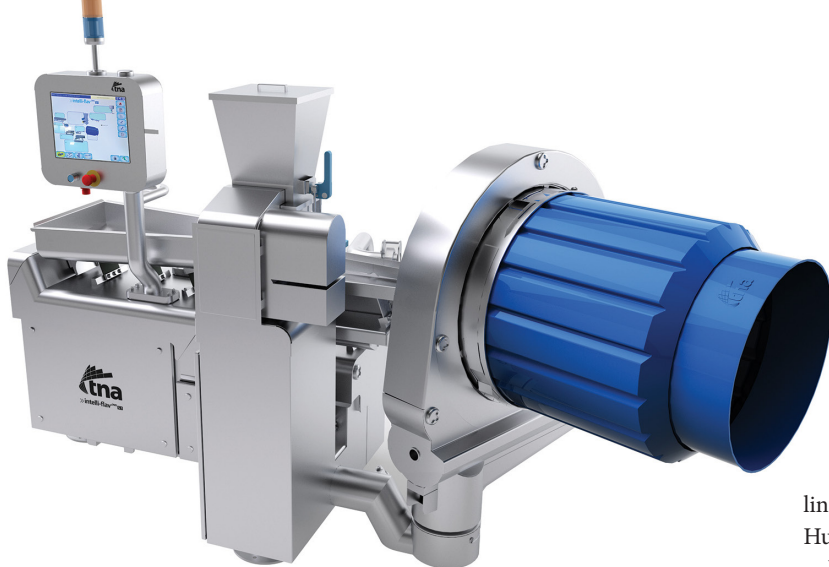
- offer precision handling of multiple pan sizes
- your desired pan stack height
- work with most existing pan carts
- maximize uptime for your production line

Custom engineered conveyor systems allow for the seamless integration of our RoboStack system into your bakery's existing footprint or new expansion. It all stacks up to the world's most efficient operation in daily pan logistics.

Call today to be the first in line to have our new RoboStack system installed in your bakery.  
**877.222.7929**

*A Fresh Approach To Custom Automation®...*

 **CAPWAY**  
**AUTOMATION**  
capwayautomation.com



Hygienic design  
on seasoning  
equipment can  
reduce the risk of  
cross-contamination  
between  
changeovers.  
TNA solutions

as possible, and for those smaller manufacturers, they've added an XY Table so operators can automatically load pans full of product with the click of a footswitch.

Mr. Roesler noted that RBS's low-pressure extruder has historically been one of the company's most dynamic pieces of equipment.

"Whether it's gluten-free or wheat-based, it's the same general process," he said. "Its flexible design features tool-free disassembly and the die and compression head are easily removeable."

Flexibility doesn't end after processing. The seasoning side of production often needs to be the most flexible of all, with new flavors providing the fastest way for snack manufacturers to add new products. For seasoning systems, cross-contamination is one of the biggest challenges during changeovers.

"Additional time is generally added to clean the line and reduce the chances of these occurrences," Mr. Hughes said.

Burford designed its FD2040 Sanitary Duster to be easily disassembled and cleaned to reduce the risk of cross-contamination. The hopper's back plate, agitating and dispensing mechanisms as well as other components have all been designed with tool-less removal for efficiency.

To prevent cross-contamination, TNA designed its intelli-flav OMS 5.1 to meet IP65 (NEMA4) specifications for wet washdown environments. That means its hygienic design includes smooth food-grade stainless steel surfaces and specialized welded joints. The flavor



## **FLX** THE ONE STOP SUPPLIER FOR FLEXIBLE PACKAGING.

The new FLX HUB is where the production of all machines in the flexible packaging chain converge. Everything needed to process all types of flexible packaging for the Food, Pharma, Wet Wipes and Pet markets is right here. The full array of leading technologies brought together in one facility, where a one-stop supplier drives the quest for excellence, sustainability, constantly researching innovative solutions and new eco-compatible materials.

**IMA FLX HUB. Flexpect more.**

[www.ima.it](http://www.ima.it)

VISIT US AT

**PACK EXPO LAS VEGAS**

LAS VEGAS, USA • 11-13 SEPT. 2023 • STAND C-3200/3400

**IBA**

MUNICH, GERMANY • 22-26 OCT. 2023 • STAND B1.310

**IMA** ILAPAK

**IMA** DELTA SYSTEMS

**IMA** EUROSICMA

**IMA** RECORD

**IMA** CIEMME

**IMA** TECMAR





**HEAT AND CONTROL**

# Helping you bring your best products to market.

## Delivering Results.

With Heat and Control, you have a partner with the scale to support your success, the innovation to advance your operations, and a commitment to quality that will help you offer better products for consumers.

## COMPLETE SNACK FOOD SOLUTIONS

- Potato and vegetable preparation
- Frying and oil management
- Drying and roasting
- Seasoning and flavoring
- Conveying and product handling
- Weighing, bagmaking, and casepacking
- Foreign object and defect inspection
- Controls and information systems

We are successful when you are successful. That's why we apply creativity, engineering excellence, and determined perseverance to every project to help our customers get the performance their business demands—whether measured by flavor, efficiencies, sustainability, improvement, or innovation.



Sep. 11-13, 2023  
Booth C-1623, Central Hall  
Las Vegas Convention Center  
Las Vegas, NV USA

[info@heatandcontrol.com](mailto:info@heatandcontrol.com) | [heatandcontrol.com](http://heatandcontrol.com)

FastBack



MASTERMATIC

ISHIDA



LOOKING BACK. PRESSING FORWARD. ALWAYS INNOVATING.

## FOR SEASONING SYSTEMS, CROSS-CONTAMINATION IS ONE OF THE BIGGEST CHALLENGES DURING CHANGEOVERS.

kit is also designed for tool-less changeovers and the machine features a lightweight drum.

“These advancements in seasoning equipment streamline the changeover process, enabling snack manufacturers to respond swiftly to consumer trends and demands,” Mr. Cope said. “With efficient changeovers, manufacturers can keep up with market demands, reduce downtime and optimize production efficiency while ensuring consistent and even seasoning of their products.”

On-machine seasoning (OMS) systems, Mr. Svejksky pointed out, can offer flexibility in that they do not require the entire processing line to be turned off

or even throttled back during flavor changes. This keeps production moving on the same base if only changing flavor profile. OMS systems once were limited to certain products, but that’s no longer the case.

“In the past, OMS was only applicable for certain products because of issues with seasoning quality,” Mr. Svejksky said. “With the latest technology improvements incorporated into the FastBack Revolution Seasoning Systems’ OMS, such as AccuFlavor tumble drums, performance auto feed adjust, dynamic tumbling action and totally automated seasoning control, the seasoning quality of OMS is equal to or better than traditional systems. Now both corn- and potato-based snacks, along with other snack products are candidates for OMS.”

With innovation back and consumers seeking snacks to satisfy their every need, snack manufacturers are searching for equipment to overcome their every challenge. With flexibility and control at the forefront of equipment design, they may find just what they’re looking for from equipment suppliers. ●

# NEVER OBSOLETE INSPECTION SYSTEMS

**Accurately inspect bakery & snack products** for metal contamination and weight conformity.



Find out more about how our equipment can enhance your processing line at Pack Expo Las Vegas: **BOOTH 4303!**



**LEARN MORE ABOUT OUR  
EQUIPMENT ONLINE**

[sales@fortresstechnology.com](mailto:sales@fortresstechnology.com) | (416) 754-2898

**FORTRESS**  
TECHNOLOGY





## RS 100 Series from Risco: Welcome to cookie production

The Risco RS 100 vacuum filler series has a compact design suitable for small to medium size production, producing top quality products at maximum speed. Several complementary accessories are available for an all-accomplished production. The RS 100 series is ideal for all types of cookies. With a gentle pump design, product inclusions stay intact while being precisely portioned. If you want to start or improve your current production of cookies, muffins, cakes, pies or other bakery products, then Risco is the ideal partner for a competitive and better product, with an efficient production.



### Risco USA Corporation

60 Bristol Drive | South Easton, MA 02375 | Tel. 508 230 3336 | Fax 508 230 5345 | [info@riscousa.com](mailto:info@riscousa.com)

Partner in your success

# Hot upgrade for cool performance

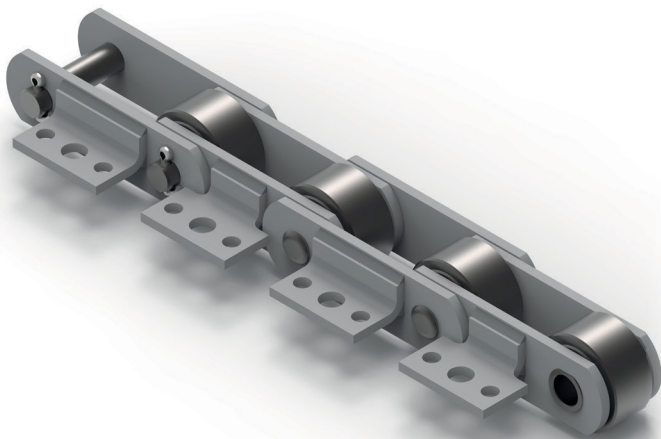
Cutting edge technology from Germany for the worldwide industry



KettenWulf oven chains and sprockets are designed and manufactured with German quality. KettenWulf will work with customers to replace existing chains and sprockets and/or upgrade the chains and sprockets to be better suited for your oven's environment. KettenWulf chains and sprockets have beneficial features that are available including:

- Precision machined and cut components for optimal performance and fit
- State-of-the-art hardened wear components (pins, bushings, rollers) for maximum wear life
- Smooth wear surfaces for minimal friction for smooth operation and maximum wear life
- High strength and fatigue resistant design to minimize fractures
- Customizable attachments to connect to any flight
- Special alloys and stainless steels available for hot\* environments
- Furthermore, KettenWulf offers "lube free" designs for certain applications\*

*\*consult with KettenWulf Engineering*





# latest **BUZZ** on **OVENS**

EQUIPMENT  
Ovens



Bakers need to weigh the pros and cons to determine the potential of thermal electric heat for their operations.

by Dan Malovany

Don't worry. The government isn't taking away your gas stove anytime soon. However, pending local regulations, the global groundswell toward clean energy and sustainability are reigniting the interest in thermal electric heat for commercial baking ovens.

Specifically, wholesale bakeries around Los Angeles will be required to replace their natural gas-fired ovens that are more than 22 years old with electric ovens or other low nitrogen oxide (NOx) burners by 2027, according to a proposed rule by the South Coast Air Quality Management District (SCAQMD) Governing Board. If the proposal is enacted, the major concern is that the movement in Southern California could spread to other regions throughout the nation.

The issue begs several questions: How viable are electric ovens as an alternative to affordable natural gas alternatives? Can they produce the same wide variety of baked goods with comparable quality and at existing high volumes? Can the local power grid or infrastructure within bakeries support the switch? Will the EO, or electric oven, become the EV, or electric vehicle, of baking? That depends on a host of factors that determine if an electric or a hybrid combination of electric and fossil fuel thermal heat fits into a bakery's operation.

Consider the benefits of lifting the peddle off the gas and converting to electric heat.

"In terms of advantages, the design of electric ovens, which do not require gas piping or venting systems, makes operations simple and might reduce installation and maintenance costs," said Nicola Menardo, president of TP Food Group, North America. "During the oven startup phase, electric ovens that feature specific systems for heat modulation allow simple and precise temperature controls."

He added that electric ovens can reduce carbon footprints compared with gas-fired ovens if electricity is generated from renewable energy sources. Moreover, operational cost savings are possible in those countries where electricity is cheaper than gas, but there are some other issues to consider.

"In terms of limitations, electric ovens can drive electricity absorption loads, and not all baking facilities have the tools to cope with this," Mr. Menardo said. "In our experience, electric ovens do not reach the values of radiating heat attainable with diathermic oil ovens. The lower flexibility in radiant heat adjustment might then reduce the mix of products that one can bake. Gas prices cheaper than electricity costs erode the potential cost benefits of electric ovens."

Many companies offer a panoply of alternatives. Reading Bakery System (RBS), for instance, provides an electric option for its convection ovens.

Hybrid and electrical technology have improved significantly in recent years, providing both energy savings and flexibility to bake a wider variety of products.

AMF Bakery Systems



## OVENS

"Customers can easily exchange their gas penthouses with electric penthouses," said Tyler Martin, R&D engineer, baking systems, RBS. "The opportunity with electric heating is carbon-neutral energy. The challenges we see with this type of heat include higher initial and operational costs, slightly longer heat-up and response times and the need for more power than is currently available."

Auto-Bake Serpentine also offers an electric retrofit of its gas-fired convection oven. This allows bakers to purchase a new gas-fired oven today, then transition it in the future, noted Scott McCally, president of Auto-Bake Serpentine, Hinds-Bock and Inline Filling Systems, all part of Middleby Bakery.

"The immediate reaction from bakers has been for original equipment manufacturers to consider hybrid gas-and-electric systems that use gas-fired burners to heat up the system initially or to aid a quick response to an immediate and substantial load," he said. "During production, however, electric heat is the primary energy source. The benefits include a reduction of fossil fuel usage and potentially a reduction in the bakery's daily energy costs."

However, Mr. McCally added, this response to the current environment would be temporary, and he provided a reason why bakers might consider the switch to all electric.

"Elimination of fossil fuel usage is inevitable; the only question is when and where the regulators will mandate the transition," he explained. "In 2023, bakers should be considering electric ovens for any asset that will be depreciated for more than seven years. Given that the useful life of a bakery oven can be more than 20 years, it makes sense for bakers to get the most from their existing ovens and then replace them with a new electric oven within the next seven years."

### The buzz gets louder

Consumers' awareness about carbon footprint and other green initiatives has prompted an increasing number of retail and foodservice chains to request that their bakery suppliers provide documentation about their sustainability programs. The baking industry has responded by being one of the leading participants in the Energy

## **Macrowave<sup>TM</sup>** **Bantam-Series Post-Baking Dryers**

**Get the Productivity Lift You Need  
From the Oven You Already Own!**

- ▶ **Simple Robust Design**
  - Perfect for 1 meter wide bands
- ▶ **New Air-Cooled Generator**
  - For Low Capital, Installation & Maintenance Costs
- ▶ **Increase Productivity 30% or More**
  - Eliminate Checking
  - Control Moisture & Color
  - Reduce Water Activity



**New**  
**Macrowave<sup>TM</sup> Bantam-Series Dryer**

RFC's OmniTherm Simulator<sup>TM</sup> available  
for determining if your production can  
benefit from the Macrowave<sup>TM</sup>  
Pasteurization Process.

**Radio Frequency Co.**  
INCORPORATED

150 Dover Road, P.O. Box 158, Millis, MA 02054-0158  
Tel. 508-376-9555 Fax 508-376-9944

[www.macrowave.com](http://www.macrowave.com)



Star program by the US Environmental Protection Agency.

The groundswell of interest in sustainability is also fueling the exploration of low-emission burners and heat recovery systems. Mecatherm, for instance, is developing advanced energy recovery systems that will be unveiled at iba 2023, the international trade show that runs Oct. 22-26 in Germany.

Franck Ellenbogen, sales director, North America, Mecatherm, explained that total energy consumption is always split between useful energy, which is used for heating products, and lost energy that's used to heat oven walls, belts and fumes. Ovens also spend a considerable amount of energy on airflow management. Mecatherm, he said, focuses on reducing energy losses and incoming fresh air management to create more sustainable ovens.

Mr. Ellenbogen suggested a hybrid or all-

electric oven provides two main advantages. They either minimize or eliminate carbon dioxide (CO<sub>2</sub>) and NOx emissions. Second, they decrease energy consumption because only low or no fumes are emitted.

Overall, electric oven technology has progressed significantly during the past few years, noted Phil Domenicucci, baking systems specialist, AMF Bakery Systems.

The operational advantages of electric heating, he said, include a fast response to set point changes, very even heat distribution and reduced maintenance. On the other hand, the power

---

Electrically heated rack ovens have been available for a long time, but advances in technology have made them a more popular sustainable option in recent years.

Koenig Bakery Systems



**BE AGILE**

**A unique oven for a changing world**



Flexibility, advanced industrial performance and product quality. The M-TA oven has everything covered to give you that competitive edge. It can produce an almost infinite variety of bakery and pastry products in a market that is constantly growing and evolving.

Contact us at [info@mecatherm.fr](mailto:info@mecatherm.fr)

**Make your industrial bakery simpler**

  
**MECATHERM**

## OVENS

For some bakeries, the simple design of electric ovens, which do not require gas piping or venting systems, could reduce installation and long-term maintenance costs.

TP Food Group

use of electric ovens must also be considered because some bakeries do not have enough incoming power to run a large oven. AMF offers electric burners for Vesta Tunnel and Tray ovens as well as the Den Boer MB-E Electric Tunnel ovens in sizes ranging from 800-mm (32-inches) to 4-meters (160-inches) wide and from 4.4-meters (14.4-feet) to 62.4-meters (205-feet) long.

Mr. Ellenbogen said electric heat can lower energy consumption by up to 15% on Mecatherm ovens and reduce maintenance on burner and chimney ducts that's typically needed for gas-fired ovens. He added vertical and tunnel ovens such as the company's M-TA and FDA models can be switched to electric supply.

Electric ovens generally need less exhaust due to the lack of products of combustion. Mr. Martin said extremely accurate proportional-integral-derivative loop controls help create a steady baking environment for

## Making the leap to ELECTRIC HEAT

Bakeries that invest in electric ovens may have to adjust their process, depending on their product portfolio and the type of oven used.

"Electric heating is a suitable replacement for almost all products if you take into consideration the reduced absolute moisture profile in the baking chamber," said Phil Domenicucci, baking systems specialist, AMF Bakery Systems. "In direct-heated natural gas ovens, moisture is a by-product of combustion. This moisture is part of the oven baking profile for all products. Since electric heating has no moisture by-products, the product baking profile must compensate for the lack of moisture."

Some systems like convection ovens can use thermal electric heat effectively with little or no impact on products.

"Most baked products that can be run through a modern forced convection tunnel oven can be run without issue using electric power," said Jerry Barnes, vice president, Babbco. "The core heat transfer methods remain the same, regardless of power source, limiting changes to the bake profile. Concerns about moisture in the bake chamber are largely unfounded, as moisture from the combustion process is a small fraction of the moisture generated in bake-off. Exhaust control becomes the key in this instance."

Specifically, it's the heat delivery system of conduction, convection and radiation, not a fuel source like electricity, that determines what's best for baking specific products, observed Scott McCally, president of McCally, Auto-Bake Serpentine, Hinds-Bock and Inline Filling Systems, all part of Middleby Bakery.

"Throughput also is not impacted by the fuel source," he said. "All other systems being the same, the product requires the same energy density for baking regardless of the fuel source."

Mr. McCally added that electric heating allows for a wide turndown ratio of nearly zero to 100% of the power range of each element and the entire system.







September 11–13, 2023  
Las Vegas Convention Center  
Las Vegas, Nevada USA

**BOOTH #SL-6380**

# THERE'S NO STOPPING

## BAKETECH



**BAKERY SYSTEMS**

A Markel Food Group Company



Scan to learn more

## *CONTINUOUS PROOFERS, OVENS, AND COOLERS*

Engineered with twice as many burners as competing industrial ovens, AMF BakeTech Continuous Oven Systems ensure exact heat placement, pan after pan, for the most uniformly baked products. BakeTech's flexible design and unmatched reliability lowers the cost of ownership by offering interchangeable parts, automated chain oiling, proprietary Emisshield® coatings to extend chain life, and dedicated repair and modernization teams.

[AMFBAKERY.COM](http://AMFBAKERY.COM) | [SALES@AMFBAKERY.COM](mailto:SALES@AMFBAKERY.COM)

© 2023 AMF Bakery Systems

USA | Netherlands | UK | China | Singapore | Canada | Mexico



## —BAKE MORE, BAKE BETTER WITH IPCO STEEL BELT TECHNOLOGY

Our solid and perforated steel belts have helped bakeries produce premium quality products for almost 100 years. Flat, straight, durable and easy to clean, they provide a baking surface that's ideal for everything from rich, chewy all butter cookies to traditional biscuits and crackers.

The other reason for choosing IPCO is our global service capability, providing the reassurance of premium productivity too.

- ✓ High productivity wide belts up to 3500 mm.
- ✓ Maximum versatility – bake more on an IPCO steel belt.
- ✓ Energy efficient – lighter belt means lower carbon footprint.
- ✓ Belt only or full range of conveyor components.
- ✓ Installations, upgrades (mesh replacement), repair, maintenance and spare parts.

Read more at [ipco.com/bake](http://ipco.com/bake)



See us at IBA  
Munich · 22-26 Oct · Hall C1 Stand 120



## OVENS



Bakeries can easily transition from gas penthouses in convection ovens to electric ones for carbon-neutral heating.

Reading Bakery Systems

product consistency, but also assist in maintaining constant energy consumption while eliminating large energy spikes.

Jerry Barnes, vice president, Babbco, pointed out electric heating efficiency is also greater due to modern silicon-controlled rectifier devices and almost unlimited control range.

“The significant advantage, though, is that oven exhaust can now be dialed much lower, retaining more heat in the bake chamber,” he said. “Equipment uptime is improved, as gas safety devices, gas trains and the necessary expertise to maintain them goes away.”

A bakery's location goes a long way in whether to go electric, said Ken Johnson, president, Gemini Bakery Equipment. Internationally, it makes sense in some countries.

“The primary advantage when replacing fuel heating with electric elements is that the exhaust gas losses from the oven are eliminated,” he explained. “This results in a 12% to 15% energy savings. The primary disadvantage when using an electrically heated tunnel oven in North America will most likely be the cost of the electricity required. All products that can be baked in a gas-fired indirect tunnel oven can be baked in an indirect electric-fired tunnel oven provided that the electric heating elements are properly sized for the application.”

When it comes to baked snacks, an electric oven's performance is similar to a gas-powered one. That's what RBS discovered after installing an oven at its innovation center and running organoleptic tests and pilot research and development on snacks.

“We saw that the same snacks can be successfully made on the electric-powered oven and with the same quality, textures and taste,” Mr. Martin recalled. “While the electric





COOKING &  
BAKING



## OV520 Rotating Rack Ovens

Baking and Cooking to Perfection

### RACK AFTER RACK

In today's market, success will come from rethinking operations and adoption of new technologies and cooking methods that are driving greater efficiencies and profitability. Whether it's bakery or culinary menu items, a Baxter rotating rack oven offers both the flexibility and responsiveness to achieve your production goals. Our design and technology results in ovens that deliver high food quality in less time with lower operating costs.

Contact a Baxter sales representative today at  
**[baxtermfg.com](http://baxtermfg.com) or (888) 350-7090**



Gas Models Only



**Proven technology. Authentic results.**

Baxter is a division of the ITW Food Equipment Group of premium brands.

**OV520 Rack Ovens are available in  
single and double rack models, gas or electric.**



HYBRID OVENS OFFER BAKERS A SIGNIFICANT AMOUNT OF FLEXIBILITY, BOTH IN THE PRODUCTS THEY BAKE AND POTENTIALLY IN THE ENERGY SAVINGS THEY GENERATE.



oven is slightly less responsive to a temperature adjustment, the baking process is more energy efficient due to less products of combustion and less humidity needing to be exhausted.”

### Versatility and sustainability

Hybrid ovens offer bakers a significant amount of flexibility, both in the products they bake and potentially in the energy savings they generate. However, Mr. Domenicucci cautioned, converting existing ovens to hybrids might not be economically practical, especially for older ovens.

“New ovens can easily be built with combination gas and electric heating,” he said. “Heating could be switched between fuel sources depending on the product and availability and costs of the fuel.”

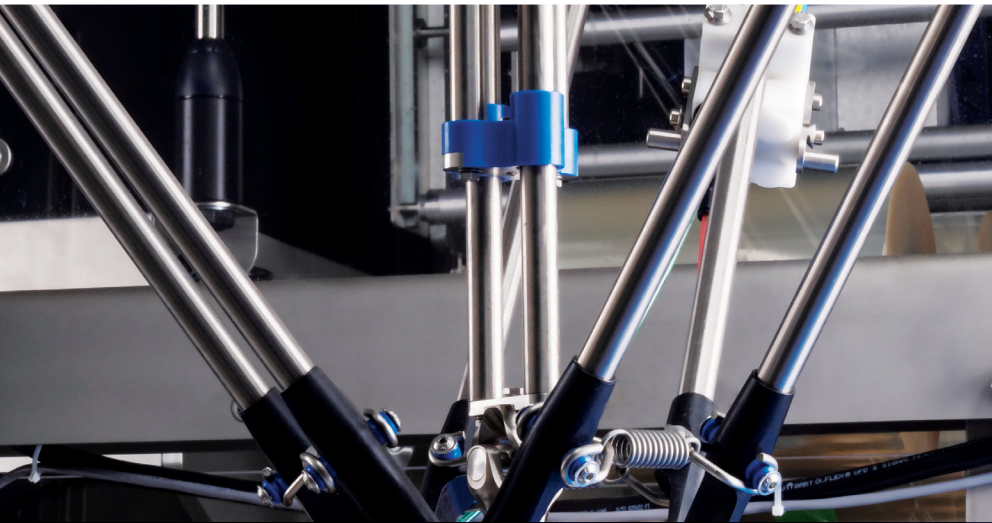
At iba 2023, AMF will exhibit a Vesta oven section with natural gas, hydrogen and electric heating along with its BakeTech oven burner set-ups.

Babbco has recently developed the Babbco CleanBake multifuel air-impingement tunnel oven, which can combine natural gas, propane or hydrogen burners with electric heating elements.

Mr. Barnes said this hybrid technology can run initially on gas, with the ability to switch over to full electric power, achieving zero emissions at a future date.

“This very beneficial feature allows easy migration from fossil fuels to electric as plant power distribution networks are upgraded,” he explained. “In short, the oven is designed as future-proof. It can be purchased now with existing plant infrastructure in place, then updated to maintain regulatory compliance. The core heat transfer methods remain the same, regardless of power source, limiting changes to the bake profiles.”

For Auto-Bake, the Rapid Fossil



DO MORE  
WITH LESS

JLS® is the trusted source for flow-wrapper loading. Safe, accurate placement with IP69K rated delta robots. Fill labor gaps. Enhance food safety.



Visit us at PACK EXPO  
Booth #6156

September 11–13, 2023  
Las Vegas, Nevada USA



**TALON**  
PICK & PLACE SYSTEM

EXPERIENCE FOR YOURSELF AT  
[jlsautomation.com](http://jlsautomation.com) | 717-505-3800



- CUSTOM-DESIGNED OVENS
- DIRECT-FIRED OVENS
- INDIRECT-FIRED OVENS
- AIR IMPINGEMENT OVENS
- INFRARED OVENS
- RADIANT-TUBE OVENS
- THERMAL-OIL OVENS
- ELECTRIC OVENS
- HYBRID OVENS
- BAND OVENS
- SANITARY WASH DOWN



**BABBCO**<sup>TM</sup>

TUNNEL OVENS Since 1918

Any Oven. Any way. Anywhere.

# THE FINEST CUSTOM TUNNEL OVENS ANYWHERE IN THE WORLD



A MEMBER OF:



THE **BABB** GROUP



Ask us about our CleanBake Multi-Fuel Hybrid Heating Technology.  
Clean Energy Solutions with same Superior performance.

TEL: 508-977-0600 | EMAIL: [SALES@BABBCO.COM](mailto:SALES@BABBCO.COM) | [WWW.BABBCO.COM](http://WWW.BABBCO.COM)



A hybrid or all-electric oven can reduce carbon dioxide and nitrogen oxide emissions because only low or no fumes are created.

Mecatherm

Fuel Free (RF3) Convection Oven combines convection heating with radio frequency to reduce bake time by up to 50% in products with high fat and high hydration.

Mr. McCally said this hybrid oven technology has the potential to quickly compete at a similar operating cost per unit of production output of traditional gas-fired ovens.

## WILL THE EO, OR ELECTRIC OVEN, BECOME THE EV, OR ELECTRIC VEHICLE, OF BAKING? THAT DEPENDS ON A HOST OF FACTORS.

At iba, Auto-Bake will demonstrate its all-electric F3 Convection Oven. Other Middleby Bakery companies like Sveba Dahlen will feature its high-temperature electric Artista Deli tunnel oven, while Baker Thermal Solutions will showcase its Rapid Bake tunnel oven that combines impingement and radio frequency heating.

Meanwhile, RBS will roll out its new Emithermic XE Oven design at iba. Instead of ribbon burners, the Emithermic XE Oven bakes using electric radiant heat elements, high-radiant Thermatec panels and convective heat.

"The Thermatec panels and electric heaters deliver a more balanced heat to the product and impart the high-radiant energy required to develop the flavor and texture of the crackers," Mr. Martin explained. "For greater flexibility and control, the Emithermic

XE Oven includes a humidity-controlled product zone. Additionally, maintenance is simplified, as electric oven components are easily replaced, eliminating costly downtime replacing, cleaning and tuning gas burners.

Mr. Johnson noted Werner & Pfleiderer, which Gemini represents in North America, will display the new Thermador-E electric indirect gas-fired tunnel oven at iba. The oven's modular electric heating element assembly is designed to be a replacement for the gas burner and combustion chamber in the current W&P Thermador gas-fired ovens. Electric heat can also be retrofitted in these ovens.

### Racking up savings

The TP Food Group offers single and dual deck tunnel ovens that are fully electric and come with baking surfaces of up to 270 square meters (2,900 square feet). Mr. Menardo pointed out the ovens come with steaming sections, steam regulation systems, reliable belt transmission systems, efficient insulation, air turbulence systems, air/steam recuperation systems and separate baking zones.

For artisan and mid-sized commercial bakeries, sustainable electric rack ovens have been around for a long time. Koenig Bakery Systems offers an electric version of the Roto Passat SE rack oven.

In addition to reducing CO<sub>2</sub> emissions, the electric rack oven reaches its desired temperature quickly, even when changing programs for different products, said Christian Benedikt, group leader, oven design for Koenig.

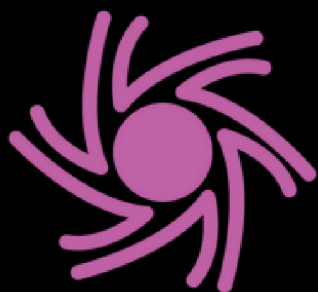
"Installation is very simple as compared to oil or gas heating. You do not need a flue gas chimney for flue gas," he pointed out. "It's an almost maintenance-free operation because the oven does not contain a burner. This means faster commissioning and no need for annual statutory inspections."

At iba, Koenig will feature its Roto Passat SE with a "Save Energy" option that offers greater energy efficiency in a smaller footprint. Moreover, several rack ovens can be connected with Koenig's newly developed Smart Connect system.

"This means that ovens can be controlled digitally, monitored and analyzed in the office by the operation manager," Mr. Benedikt said.

While many regulatory questions and operational challenges remain when it comes to sustainability, the opportunities are almost electrifying with the current and emerging advances in emission-controlling and energy-saving technology for ovens. ●

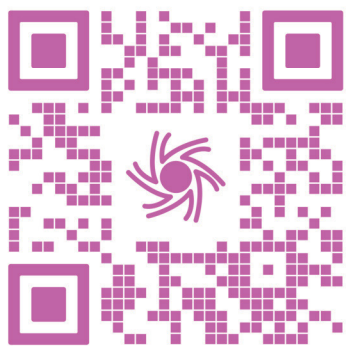




# NEXUS

Powered by BEMA and ABA

*Sourcing Sophisticated Solutions For The Baking Industry*



SCAN ME

**SEPTEMBER 25-28, 2023**

**DALLAS, TEXAS**

**OMNI DALLAS CONVENTION CENTER**

- Team to team meetings where bakers and suppliers **ENGAGE**
- Educational sessions where analysts and experts **INFORM**
- Teamwork opportunities where companies and their teams can **SHARE**

**CONTACT US**

[info@nexusofbaking.com](mailto:info@nexusofbaking.com)

# prepare to be wowed

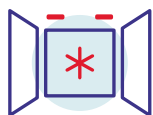


**PACKAGING.  
PROCESSING.**  
**ONE POWERFUL SHOW.**

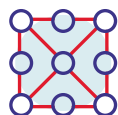
SEPT. 11-13  
**2023**  
LAS VEGAS

## Explore Total System Solutions for Baking and Snack

From groundbreaking processing equipment to flexible robotic systems to eco-friendly materials and flexible packaging solutions—at **PACK EXPO Las Vegas** you'll find everything you need to automate baking and snack production, save energy, increase speed, refresh a brand and more. Get ideas from other industries and discover surprising innovations for your products.



**2,000**  
exhibitors



**40+**  
vertical markets



**100+**  
free show floor  
sessions



**Endless**  
networking  
opportunities

Featuring



**The  
Processing  
Zone**



**Newly Expanded**

**REGISTER NOW at [packexpolasvegas.com](https://packexpolasvegas.com)**



The Association for Packaging  
and Processing Technologies





# a vision for the **FUTURE**

E-commerce, robotics and vision systems are moving packaging forward.

by Michelle Smith

Bakeries and snack manufacturers have a lot of needs in their packaging departments today. Not only do they need the most efficient, high-throughput machinery, they also are looking for flexibility as consumer and customer tastes and budgets change.

Equipment manufacturers are pushing forward to find better ways to meet those needs and help producers package their goods safely and adroitly.

Advances are being made in several areas, including robots, cobots, vision systems, sustainable packaging and more. Sometimes many of those elements come together.

"Lately, we're finding more applications where there's a combination of robotics, vision and artificial intelligence where AI is used to identify the best way to pick up the product, the best way to handle the orientation of the product," said Jorge Izquierdo, vice president of market development, PMMI. "In many cases in bakeries, you have many different formats for the same product."

For instance, lines may be running one product but packaging it in different formats.

"You need to position not just the product but also

sometimes the dividers or the different layers for protection, and a robot is able to do both things and provide a lot of flexibility," he added.

## Keeping a watchful eye

Vision systems not only enable automated quality assurance, they optimize packaging efficiency by detecting production position, orientation and shape while also streamlining processes, reducing waste and improving productivity, said Kimberly Kocer, product manager for Syntegon.

"While there have been notable advancements in various areas, advanced vision technology has revolutionized packaging processes, introducing precision, efficiency and quality control," she said. "It can accurately identify and inspect products, ensuring package integrity and minimizing errors. For commercial bakeries and snack makers, this innovation offers significant advantages."

The use of vision systems for quality control of both products and packaging is one of the most promising innovations, said Christian Romualdi, group marketing

Extended reality technology is assisting with training, maintenance and planning in packaging areas.

©Justin-stock.adobe.com



As manufacturers explore more sustainable packaging, it's important to have machines that can handle alternative materials.

TNA solutions

and communication manager, IMA Ilapak. Monitoring and controlling all packaging parameters, such as sealing and product position, keeps productivity and efficiency high.

"Simply put, machines must be able to record everything that happens and interpret the signals to take immediate actions," Mr. Romualdi said.

TNA solutions has developed and continues to improve augmented reality and virtual reality (AR/VR) tools to help customers plan and maintain packaging solutions.

"Over the past year, extended reality (XR) has emerged as a prominent technology, empowering manufacturers to gain valuable insight before implementing physical actions," said Mukul Shukla, vice president, North America, TNA.

The company offers interactive digital twins of planned or existing operations, giving customers with a VR headset the ability to enter virtual versions of their factories and test different configurations before building the plant. Operators can be virtually trained on production lines with this technology. AR technology assists with remote maintenance sessions as operators can share what they're seeing with technicians who can guide them with repairs or line adjustments.

"These XR and AR capabilities revolutionize the manufacturing landscape, offering unprecedented insights,

training opportunities and remote support for enhanced operational efficiency," Mr. Shukla said.

Bill Kehrli, vice president of sales and marketing for Cavanna Packaging, envisions a not-too-distant future that includes cobots mounted on AGVs performing a variety of tasks.

"The technology is there today and I think when people are ready to do this, they should seriously consider it," he said. "Is it doable? Yes. Is it doable for every job function? No, not yet. That's one thing with AGVs, predictive maintenance and industry 4.0. There's a lot going on, and that's exciting."

### Meeting evolving needs

As e-commerce grows, the packaging needs of bakers and snack makers are changing, according to a 2022 PMMI report, "The Future of Automation in Packaging and Processing." Pack sizes are expected to shrink and take different formats because items are being shipped directly to consumers.

"Many times when it goes to the supermarket it needs to have a nice display. That's maybe the No. 1 thing," Mr. Izquierdo said. "Of course, it has to have a certain strength. The combination flips when it's e-commerce. The way it looks is not as important. Sometimes in a supermarket it's important because it's how the consumer makes the decision. In the case of e-commerce, the decision has already been made. Yes, you want nice packaging consistent with your branding. You need packaging that's more resilient and can handle all the shipping."

**"AS THE NUMBER OF E-COMMERCE AND D2C ORDERS CONTINUES TO GROW OVER THE NEXT FIVE YEARS, ORDERS ARE LIKELY TO BECOME MORE PERSONALIZED."**

2022 PMMI Innovation report

Jason Hogue, southeast regional sales manager for BluePrint Automation, said the most promising packaging innovation — popular among both food producers and co-packers — involves large offline decoupled packaging systems for variety or standard packs.

"These were traditionally done at co-pack facilities with a large human labor force," he said. "The system does not need to be tied directly to a wrapper or bagger. Products can be made and stored, then pulled out to



DOBOY  
ELEMATIC  
KLIKLOK  
MAKAT  
OSGOOD  
SIGPACK  
WOODMAN

## Many players, one team.

Many players working hard to ensure the productivity, safety, and sustainability of our machines are always at their best. One team dedicated to providing exemplary service — every time.

Visit us in  
Las Vegas!

**PACK EXPO**  
Booth C-2800

[www.syntegon.com](http://www.syntegon.com)

**SYNTEGON**

PROCESSING & PACKAGING



Large offline decoupled packaging systems can be used for variety or standard packs.

BluePrint Automation

make these specialty packs with minimal labor.”

Producers are clamoring for increased capacity for small bags, Mr. Almond said.

“This lends itself to machines that can produce snacks at a high rate of speed in less space,” he said. “We are also working on solutions to handle those bags post packaging to improve operation efficiency where possible.”

The PMMI report stated that order fulfillment will become more complex as direct-to-consumer (D2C) orders rise.

“As the number of e-commerce and D2C orders continues to grow over the next five years, orders are likely to become more personalized, with the possibility of consumers, for example, choosing their own recipe ingredients or products in a variety pack,” according to the report. “New plants may need to be built with the e-commerce factor in mind and designed for end-to-end automation.”

## WHEN IT COMES TO COMMUNICATION BETWEEN PRODUCERS AND OEMS, MORE IS MORE.

Ms. Kocer said customers are adapting their packaging processes to accommodate the shift to e-commerce to ensure products are protected in transit to consumers.

“To meet these evolving packaging needs, our customers have focused on implementing agile and flexible packaging solutions that can handle diverse package sizes and formats, enabling quick changeovers and customization options,” she said.

Heat and Control’s customers are primarily focused on using existing technology more effectively and providing advanced training for staff in the wake of high turnover, said Jeff Almond, industry manager, snack food packaging, Heat and Control. But versatility is also a priority.

“The rise of e-commerce has caused the need for additional flexibility in both packaging and automation,” he added. “We have been working with our customers to review existing assets and what may be needed in the future so that they can leverage

e-commerce opportunities as they arise.”

Mr. Almond said the company has been focused on ease of operation and maintenance, predictive maintenance, training tools for a fluid workforce and better understanding customers’ needs.

The lack of workforce is so critical for some customers that they are investing in packaging equipment without being as concerned about the cost, said Stephane Vieira, technical sales representative for Niverplast.

Bakers and snack makers these days need not only versatility to meet changing needs but are also looking for labor saving automation that fits into limited space in their packaging departments.

“The flexibility offered by automated equipment allows them to effortlessly switch between different formats,” Ms. Kocer said. “By implementing automated packaging solutions, bakeries can maintain consistent output levels even with limited personnel. This not only enhances productivity but also improves operational stability. Additionally, the implementation of modified atmosphere packaging through automated packaging equipment has proven to be highly effective in reducing food waste.”

Unfortunately, flexibility and efficiency can be at odds with each other. Producers have to decide which of their priorities is more important.

“If you need to be able to run everything, then you’re going to have to choose to have more labor,” said Dennis Gunnell, president, Formost Fuji. “That doesn’t mean you might not be able to automate most of it or reduce head count, but if you want complete flexibility, you’re going to give up something else.”

Equipment manufacturers are also addressing the space restrictions by offering equipment that reli-





**Need to load stacks of crackers into trays on a continuous motion tray sealing machine?**



## **The Benchmark Cracker Placer with Traveling Head**

**Cost savings:** Labor & Scrap Reduction

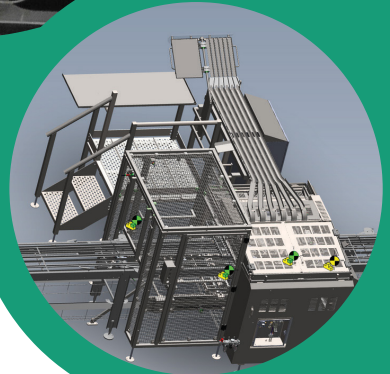
**Unparalleled consistency:** Deliver perfectly arranged crackers every time

**Increased Capacity:** The Travelling Head enables you to load crackers into a moving tray effectively and efficiently.

**Time-saving:** Free up your workforce to focus on other critical tasks

**Improved hygiene:** Washdown version minimizes contamination risks and ensures the highest food safety standards with our automated process.

**Future-proof investment:** Stay ahead of the competition and adapt to market demands with our state-of-the-art technology.



Looking to join an amazing team in Georgia? We're hiring!  
Scan the QR Code to learn about new opportunities.

Please reach out to connect with our team for a bakery processing or packaging solution today!

Phone #: (706) 208-0814  
Websites: [www.Kleenline.com](http://www.Kleenline.com)  
[www.BenchmarkAutomation.net](http://www.BenchmarkAutomation.net)





Partnerships between OEMs and producers allows bakers and snack makers to find the best solutions for their packaging needs.

Reiser

ably handles jobs in small spaces. For instance, Rexfab has introduced its Mekitec X-ray system in North America.

"This compact X-ray inspection system combines superior X-ray sensitivity with a small footprint that adds it to any bakery's packaging line," said Bernardo Zermeno, customer development director for Rexfab.

### Building partnerships

Collaboration between OEMs is resulting in seamless production lines.

Formost Fuji

PMMI's innovation report said that partnerships between food producers and original equipment manufacturers (OEMs) is transitioning from the purely transactional to collaborative partnerships, an idea that OEMs are eager to embrace.

"Previously, price/ROI would have been the No. 1 (or close to No. 1) consideration when companies were choosing a supplier or a machine," the report said.

"But the age of the transactional relationship between the CPG and the OEM is giving way to one of collaboration, support and cooperation."

Partnerships extend from setup and training through to exploration of the latest packaging materials and techniques.

"Our team of processing, baking and packaging specialists can help you develop new products, new process improvements, new packages, all in complete confidence," said Mike McCann, packaging specialist with Reiser. "Bakers are encouraged to take advantage of this opportunity to collaborate."

Mr. Shukla said TNA works to simplify integration of services and prioritizes supporting customers at all stages of growth.

"We foster long-term partnerships, considering ourselves as partners rather than mere commodity suppliers," he said. "In addition, because we integrate everything we sell, we are able to provide invaluable insight on how customers can best utilize their investment, and inspire with new ideas for optimizing their businesses."

Open communication and full disclosure are the hallmarks of a great relationship with OEMs, Mr. Gunnell said.

"The customers who are more open with information always always always get a better solution," he said.

He cited the open communication between OEMs working on a customer's line as one of the best innovations of those providing automation for bakers and snack makers. As companies understand technology better, learning how to work together and make better hand-offs has gotten easier.

"We hear people say, 'I can go to this company, and they can give me everything,' but you may not want everything they provide," Mr. Gunnell said. "But we have the ability to communicate both up and downstream and to use similar protocols and to be on the same page. Probably the most innovative thing I've seen in the last few years is how you can take five or six completely different companies, put them all together and have them be seamless. To me, that is really awesome."

He added that getting everybody on the same Zoom call or — better yet — in the same room can pay big dividends because if one OEM is having issues, keeping others informed promotes understanding and puts the other companies in a position to lend a hand if they can.







**CAPTURE THE WINDS OF CHANGE.**  
**QUICKLY, AND WITH GENTLE HANDLING.**  
**BROUGHT TO LIFE WITH SCHUBERT.**



**PACK EXPO / LAS VEGAS**

SEPTEMBER 11-13, 2023

SOUTH UPPER HALL / BOOTH 7654

WELCOME

Fresh, crispy baked goods are delicious, But they tend to crumble during packaging. Our solution: gentle robotic hands and a 3D scanner to monitor quality. In a machine that adapts to a wide variety of products in no time at all, Packaging them fully automatically in sustainable materials. In line with our Mission Blue: Only if it's good for the planet, it's good enough for our customers. [www.schubert.group/en/Confectionary-snacks/](http://www.schubert.group/en/Confectionary-snacks/)



Snack makers are looking for increased capacity to make small bags.

Heat and Control

When it comes to communication between producers and OEMs, more is more.

“If we don’t listen to them and partner with them, somebody else will,” Mr. Kehrl said.

### Going green

The search for better, more sustainable packaging is a complicated and constant struggle for bakery and snack producers who want to ensure the quality and safety of foods while working toward sustainability goals.

“That’s more and more important for consumers,” Mr. Izquierdo said. “There’s a lot of movement in that direction that’s creating significant changes in the materials that bakeries are using. If in the past you were using some type of film that has multiple layers, now you’re moving into mono-materials or in some cases, plant-based films in some specialty products.”

Companies that have used the same materials for years are testing and using new packaging more frequently, which likely requires some equipment adjustments, potentially slowing down throughputs, he said.

“When you’re changing the formulation and going to a mono-material, going to more biodegradable or compostable materials and there’s a lot of movement toward those materials now, there’s a lot of significant implications,” Mr. Izquierdo explained. “I was in a conversion with a manufacturer of form/fill/seal machines, and he was telling me how this is pushing them from using thermal sealing to ultrasonic sealing. The ultrasonic sealing provided them with a wider range of materials they can use with more flexibility.”

## OEMS ARE SERVING UP NEW AND EXCITING TECHNOLOGY THAT IS MORE EFFICIENT, EASIER TO USE AND MORE FLEXIBLE.

Ultrasonic sealing involves two bars vibrating at high speeds, and the friction seals the product. It has the advantage of being able to squeeze out any product that may be in the way but still get the job done while other sealing methods would not, he said. It also is a thin seal as opposed to the thicker thermal seals used by many manufacturers, thus saving material.

Having equipment that can pivot to new materials is vital.

“It is important to opt for packaging equipment that can handle all sustainable packaging options relevant for this segment, including the use of compostable materi-



als that can be easily composted at home,” Mr. Shukla said. “By leveraging the power of gentle rotary vertical form/fill/seal technology, snack producers can meet increasing consumer demand for sustainable packaging materials and succeed responsibly in an ever-changing landscape.”

Mr. Romualdi said he’s seeing bakeries and snack producers spend their money on flexible machinery that allows customers to process very different wrapping materials that can switch from one film to another in an automatic or semi-automatic way. That includes “machines able to easily manage critical parameters and capable of handling multiple applications without requiring specific operator skills,” he said.

The company We Seal specializes in the manufacture of recyclable tape-based bag closures and their application machines.

“Our closures are easy to open, resealable, thermal transfer compatible, have no sharp edges and use 80% less raw material than rigid plastic tags,” said Richard Hobson, the company’s chief executive officer. “Closures can be manufactured using recycled materials and are fully recyclable.”

OEMs are serving up new and exciting technology that is more efficient, easier to use and more flexible. As producers deepen their ties and improve collaboration with OEMs, they will be well-equipped to fulfill their packaging needs in the future.



# SUSTAINABLE PACKAGING SOLUTIONS *for the Baking Industry*

Sustainability is a key area of focus for most companies, with commitments made by most brand owners regarding reductions in emissions, material usage, energy consumption, and environmental impact. Packaging is an important area to consider on the sustainability journey, but true sustainable solutions need to consider the full product lifecycle. Plastic waste mismanagement is a big problem worldwide; however, among all packaging materials, plastic is the most sustainable packaging material for bakery products such as bread, buns, bagels, and tortillas. It requires less energy and water to manufacture compared to paper, it uses the least amount of material, and it provides the best barrier to minimize moisture loss, extend the product shelf-life and minimize food waste. Polyethylene bags are recyclable, although there are many challenges impacting the actual recycling of the bags.

St. Johns Packaging has been working on different sustainable packaging solutions over the past few years, looking at incorporating post-consumer recycled (PCR) content and biobased/renewable content, with the end goal of reducing the environmental impact of the packaging. With more emphasis on the circular economy, both solutions keep the materials circulating and offer a lower carbon footprint.

St. Johns Packaging launched the first commercial bread bag in the world incorporating 30% PCR content in September 2021 in the UK market. These bags provide an improved environmental

footprint versus traditional bags and allow CPGs to contribute towards their sustainability goals, offering more sustainable packaging solutions to consumers. They are still recyclable, offer reductions in the use of fossil-based materials and lower the carbon footprint of the packaging. Furthermore, the performance of these bags is very similar to that of traditional bags, minimizing the impact in the filling/ bagging equipment.

The other area of focus has been incorporating biobased/renewable materials in our bags, working with raw materials not in competition with food sources. We are able to offer bags with up to 100% biobased/ renewable content, which besides the obvious elimination of fossil-fuel usage, also offer important reductions in carbon footprint.

With a focus on the bakery market, St. Johns Packaging is truly committed to developing sustainable and economically viable packaging solutions for the baking industry, while at the same time reducing food and plastic waste. The incorporation of recycled content and biobased content are critical in the journey towards Net Zero. By supporting the circular economy, the company hopes to contribute efforts to tackle the enormous challenge of improving recycling rates, reducing the environmental impact of plastic bags and finding solutions to the plastic waste issue.

**ST. JOHNS  
PACKAGING**

[www.sjpack.com](http://www.sjpack.com)  
[info@sjpack.com](mailto:info@sjpack.com)  
1-800-567-8773  
+1-450-349-5871





# Quality Products start with Quality Dairy Ingredients

## ACCESS STANDARDS FOR DAIRY INGREDIENTS

ADPI Dairy Ingredient Standards, developed by technical and marketing experts from our member organizations, define fundamental dairy ingredients such as milk powders, as well as a host of established or emerging ingredients on the competitive edge of functionality and nutrition.

ADPI's Ingredient Resource Center offers **public access** to an extensive and ever-expanding online library featuring over 30 standards. These Dairy Ingredient Standards enable the dairy industry to fulfill its promise to deliver safe, high-quality nutrition to consumers around the world as part of our 100-year legacy of dairy industry leadership.

Visit the Ingredient Resource Center by visiting **ADPI.org**.

### Standards Available include:

- |                          |                           |                            |
|--------------------------|---------------------------|----------------------------|
| » Cream Powder           | » Dry Whole Milk          | » Reduced Fat Milk Powder  |
| » Dry Buttermilk         | » Instant Nonfat Dry Milk | » Skim Milk Powder         |
| » Dry Buttermilk Product | » Milk Protein Isolate    | » Whey Protein Concentrate |
| » Dry Whey               | » Nonfat Dry Milk         | » Whole Milk Powder        |



AMERICAN  
Dairy Products  
INSTITUTE™





# PROTECTING THE FUTURE

Cereal & Grains 23 brings back popular events with a more personal approach.

by Lucas Cuni-Mertz

The Cereals & Grains Association's annual meeting returns in full swing this year Oct. 18-20 at the Hyatt Regency in Schaumburg, Ill. Approximately 300 cereal and grain professionals across industry, government and academia are expected to attend.

This year's theme — Protecting Our Agronomic Future: From Field to Families — will feature presentations, panels and oral technical sessions covering the latest research and industry challenges such as climate change, confusion over industry regulations and evolving consumer preferences. The conference will have up to 25 sponsor tables where attendees can have meaningful conversations in a relaxed environment.

"This year we are taking a more personal approach to the science and showcasing how the science of the Cereals & Grains Association affects not only our professional lives but the day-to-day lives of everyone around the world," said Deirdre Ortiz, president, Cereals & Grains Association. "At the center of this is the exploration of how to safeguard our future and ensure access to safe, nutritious and sustainable food sources for families worldwide."

The programming includes interactive, expert-led sessions such as Breeding, Genome Editing, Food Safety and the Consumer Response; Recent Advances in Carbohydrate Ingredient Research; Diversity, Equity and Inclusion in the Agronomics Science Space; and Can a Healthy Diet Contain Processed Foods? Additional topics will be announced as the event approaches.

The meeting will also welcome Dr. Cynthia

Rosenzweig, senior research scientist at Columbia Climate School's NASA Goddard Institute for Space Studies, as the closing keynote speaker.

Returning to the conference for the first time since 2019 is the Student Association Product Development Competition.

"This popular competition allows student members to work individually or in teams to develop a novel plant-based alternative for cereal-based food products," Ms. Ortiz explained. "Their product must contain one up-cycled ingredient from Netzero and at least one underutilized cereal or legume ingredient. Our finalists will present their products at Cereals & Grains 23, where we will select three winners and award prizes."

The technical oral presentations are another welcome return to the meeting, Ms. Ortiz added.

"These have always been popular with researchers and attendees alike and allow for more extensive discussion and insight from presenters," she said.

The impact of diversity, equity and inclusion on the quality of agricultural research will be a new area of focus this year.

"Scientific excellence is at the core of all we do. All global citizens will struggle unless we help develop and maintain a diverse group of deeply committed scientists to work on the crucial topics facing our staple foods," Ms. Ortiz said.

For more information and to register for the show, visit [cerealsgrains.org/2023](https://cerealsgrains.org/2023).

Cereals and Grains 23 will be held Oct. 18-20 at the Hyatt Regency in Schaumburg, Ill.  
Cereals & Grains Association

# events

## NORTH AMERICA

### OCTOBER

- Oct. 2-4:** Energy and Store Development Conference, Baltimore; FMI  
(202) 220-0670  
[www.fmi.org](http://www.fmi.org)
- Oct. 7-10:** Food and Nutrition Conference and Expo, Denver; Academy of Nutrition and Dietetics  
(800) 877-1600  
[www.eatrightfnce.org](http://www.eatrightfnce.org)
- Oct. 15-17:** SNAC International Executive Leadership Forum 2023; Colorado Springs, Colo.  
(703) 836-4500 ext. 201  
[www.snacintl.org](http://www.snacintl.org)
- Oct. 16-18:** PMMI Annual Meeting; Stone Mountain, Ga.  
(571) 612-3200  
[www.pmmi.org](http://www.pmmi.org)
- Oct. 18-20:** Cereals & Grains 23, Schaumburg, Ill.  
(651) 454-7250  
[cerealgrains.org](http://cerealgrains.org)
- Oct. 23-25:** Process Expo, Chicago; Food Processing Suppliers Association  
[www.process-expo.us.messefrankfurt.com](http://www.process-expo.us.messefrankfurt.com)
- Oct. 23-27:** Supply Side West, Las Vegas  
(800) 299-5919  
[west.supplysideshow.com](http://west.supplysideshow.com)
- Oct. 25-26:** Fi North America, Las Vegas  
[www.figlobal.com/northamerica](http://www.figlobal.com/northamerica)

### NOVEMBER

- Nov. 9-10:** Tortilla Industry Association Technical Seminar; Tampa, Fla.  
(800) 944-6177  
[www.tortilla-info.com](http://www.tortilla-info.com)
- Nov. 12-14:** US Private Label Trade Show, Chicago; Private Label Manufacturers Association  
[www.plma.com](http://www.plma.com)
- Nov. 13-14:** ABA Fly-in and Policy Summit, Washington, DC  
(202) 789-0300  
[www.americanbakers.org](http://www.americanbakers.org)

### DECEMBER

- Dec. 12-13:** Unconventional Ag (formerly the Organic & Non-GMO Forum), Dallas  
(978) 887-8800  
[www.unconventionalag.com](http://www.unconventionalag.com)

### JANUARY 2024

- Jan. 14-16:** School Nutrition Industry Conference; Orlando, Fla; School Nutrition Association  
(703) 824-3000  
[www.schoolnutrition.org](http://www.schoolnutrition.org)
- Jan. 18-21:** FMI – The Food Industry Association Midwinter Executive Conference; Marco Island, Fla.  
(202) 220-0828  
[www.fmi.org](http://www.fmi.org)
- Jan. 19-24:** American Farm Bureau Federation Annual Convention; Salt Lake City  
(202) 406-3600  
[annualconvention.fb.org](http://annualconvention.fb.org)
- Jan. 23-27:** Wheat Industry Winter Conference; Washington, DC; National Association of Wheat Growers  
(202) 547-7800  
[www.wheatworld.org](http://www.wheatworld.org)

### FEBRUARY

- Feb. 20-22:** Wheat Quality Council Annual Meeting; Olathe, Kan.  
(913) 634-0248  
[wheatqualitycouncil.org](http://wheatqualitycouncil.org)
- Feb. 24-27:** GEAPS Exchange 2024; Kansas City, Mo.; Grain Elevator and Processing Society  
(763) 999-4300  
[www.geaps.com](http://www.geaps.com)
- Feb. 27-29:** BakingTech 2024, Chicago; American Society of Baking  
(800) 713-0462  
[www.asbe.org](http://www.asbe.org)

### MARCH

- March 3-5:** International Restaurant & Foodservice Show of New York, NY; New York State Restaurant Association  
(978) 475-4441  
[www.internationalrestaurantny.com](http://www.internationalrestaurantny.com)
- March 12-16:** Natural Products Expo West, Anaheim, Calif.  
(866) 458-4935  
[www.expowest.com](http://www.expowest.com)
- March 17-19:** National Grain and Feed Association Annual Convention; Orlando, Fla.  
(202) 289-0873  
[www.ngfa.org](http://www.ngfa.org)
- March 17-19:** National Institute of Oilseed Products (NIOP) Annual Convention, Palm Springs, Calif.  
(803) 252-7128

## INTERNATIONAL

### OCTOBER

- Oct. 22-26:** iba 2023, Munich  
[www.iba.de/en/](http://www.iba.de/en/)
- Oct. 24-25:** Tortilla Industry Association Europe Conference, Munich  
(800) 944-6099  
[www.tortilla-info.com](http://www.tortilla-info.com)

### NOVEMBER

- Nov. 7-9:** Gulfood Manufacturing; Dubai, United Arab Emirates  
[www.gulfoodmanufacturing.com](http://www.gulfoodmanufacturing.com)
- Nov. 7-9:** ISM Middle East; Dubai, United Arab Emirates  
[www.ism-me.com](http://www.ism-me.com)
- Nov. 28-30:** Fi Europe & Hi Europe 2023; Frankfurt, Germany  
[www.figlobal.com](http://www.figlobal.com)

### JANUARY 2024

- Jan. 20-24:** Sigep 2024; Rimini, Italy  
[en.sigep.it](http://en.sigep.it)
- Jan. 28-31:** ISM, International Sweets and Biscuit Fair; Cologne, Germany  
[www.ism-cologne.com](http://www.ism-cologne.com)

### FEBRUARY

- Feb. 13-16:** BioFach 2024; Nuremberg, Germany  
[www.biofach.de](http://www.biofach.de)
- Feb. 19-23:** Gulfood 2024, Dubai World Trade Center; Dubai, United Arab Emirates  
[www.gulfood.com](http://www.gulfood.com)

### MARCH

- March 8-12:** Internorga 2024; Hamburg, Germany  
[www.internorga.com](http://www.internorga.com)
- March 14-17:** Taipei International Bakery Show; Taipei, Taiwan  
[www.tibs.org.tw/en](http://www.tibs.org.tw/en)
- March 19-22:** Modern Bakery Moscow, Moscow  
[en.modern-bakery.ru](http://en.modern-bakery.ru)

### APRIL

- April 16-18:** WorldFood Poland, Warsaw, Poland  
[www.worldfood.pl](http://www.worldfood.pl)

### MAY

- May 12-15:** European Congress on Obesity 2024; Venice, Italy  
[www.eco2023.org](http://www.eco2023.org)

For more information on these events or to see a more comprehensive calendar, visit [www.bakingbusiness.com/events](http://www.bakingbusiness.com/events).



# INNOVATIONS



100

## FEATURED TECHNICAL EXPERT

**Lesaffre: Michael Bultel**

Michael Bultel has spent nearly 30 years in the milling and baking industries.



102

## INGREDIENTS & FORMULATING

**Cocoa butter substitute for baked foods**

Cebes choco 15, a cocoa butter substitute from AAK, is a compound that allows up to 15% of cocoa ingredients to enhance cocoa flavor in baked foods.



104

## EQUIPMENT & PACKAGING

**Batch weighing system for improved accuracy**

Coperion's K-Tron batch weighing system is ideal for accurate batching direct to blenders/mixers.



107 patents



108 new on the shelf

# featured technical expert Q&A

## Michael Bultel

### Lesaffre



Michael Bultel has spent nearly 30 years supporting the baking and milling industries as a food technologist.

“Being a bread lover with farmer family roots, I have always been attracted to the area of cereals,” he said.

Mr. Bultel started his career in the milling industry before joining Lesaffre in 2006, where he has since served in a variety of positions across the globe. He began at Lesaffre’s International Baking Center in France, providing product development and technical support to regional markets in Western Europe, Africa and South America. In 2013, Mr. Bultel joined Lesaffre’s Central Europe division in Croatia. He was then promoted to head of Lesaffre’s Asia Pacific Baking Center in Singapore in 2016, where he managed the company’s technical application center. Most recently, Mr. Bultel joined Lesaffre’s North America division in Milwaukee as baking business development manager last year.

“I really enjoy supporting customers, helping with innovative

baking solutions, sharing technical advice, achieving growth for their business and promoting the consumption of baked products,” he said. “Fermented products are so infinite; there is always something to learn.”

Mr. Bultel sees a lack of trained workforce, as well as high raw material costs and the trend toward cleaner labels as a few of the primary challenges bakers face today. He noted that Lesaffre helps combat the workforce issue by providing technical support and training to bakers.

“Long term, keeping consumers attracted to baked products is very important for the future of our industry, so by offering new products, recipes and technical services, Lesaffre aims to help bakeries in their development,” he said.

### What are some of the biggest cost challenges bakers face today?

Commercial bakeries face a barrage of economic headwinds. Having to contend with labor shortages and high inflation of raw materials, the costs of production have dramatically increased across the industry. On top of that, supply chain disruptions have made it more difficult and unreliable to source certain key dough improvers, such as emulsifiers, especially mono- and diglycerides (MDGs) and diacetyl tartaric acid ester of mono- and diglycerides (DATEM).

### How might costs differ based on the baked good being produced?

Obviously, cost of raw materials will be more limited in a lean dough recipe than in a rich sweet dough, such as brioche, which will be impacted much more by using many raw materials (sugar, fat, emulsifiers, preservatives). Even in a lean recipe, cost optimization can sometimes be found by using frozen dough techniques or shelf life extension.

### What are some of the biggest cost-saving opportunities for bakers?

It can be a direct cost saving when replacing emulsifiers or gluten with enzyme blends such as Star-Zyme MDG Replacer for extended shelf life, which requires a usage level three-to-six times less than traditional emulsifiers. Furthermore, Star-Zyme MDG Replacer can reduce the amount of anti-staling ingredients required in an application by 10% to 15%. Saf Pro Star-Zyme STR

701 R is also a clean label alternative to MDGs and DATEM with similar characteristics to MDG Replacer but additionally replaces sodium stearoyl lactylate (SSL), vital wheat gluten (VWG) and L-cysteine. The all-in-one formula contributes to dough relaxation, strength and tolerance, enhances volume and extends shelf life.

### How can bakers minimize costs while still maintaining product quality?

Certain doughs, like pizzas and baguettes, require long mixing times at high speeds, which can put a strain on production efficiencies. Formulating with deactivated yeast helps improve and control the manufacturing process and contributes added dough improving benefits. Increasing automation to improve productivity and compensate for workforce shortages requires bakers to find solutions to maintain high-quality dough and products. For such purposes, we see the benefits brought by Saf Pro baking ingredient solutions in maintaining the final quality of baking products.

### With the current clean label trend, how can bakers produce clean label products in a cost-effective way?

Saf Pro Star-Zyme AST 300 is another clean label enzyme blend that creates long-term softness and can lower costs for producers and retail stores. In addition to contributing to improved dough machinability, AST 300 inhibits staling and extends the shelf life of a range of applications. Finished baked goods that remain soft and fresh for longer improve efficiencies and result in cost savings for bakeries and retail stores by requiring fewer deliveries and reducing waste on store shelves.



"SUPPLY CHAIN DISRUPTIONS HAVE MADE IT MORE DIFFICULT AND UNRELIABLE TO SOURCE CERTAIN KEY DOUGH IMPROVERS, SUCH AS EMULSIFIERS, ESPECIALLY MDGS AND DATEM."

Michael Bultel, Lesaffre

**How can Lesaffre assist bakers in implementing cost-saving ingredients?**

Lesaffre has high-level technical expertise in fermentation and enzyme solutions dedicated to baking products. Consumers are looking for cleaner products, for which several Saf Pro Star-Zyme solutions have been designed that can bring softness and freshness, a preservative effect with NMI solutions, and dough strengthening.

To help bakeries satisfy their consumers in the trend for clean label, Lesaffre not only offers solutions but also service to customers through support from an experienced technical team that goes to the bakeries to advise and work along with customers.



# NEWS & TRENDS ~~~~~ *impacting* ~~~~~ THE PERIMETER



supermarketPERIMETER.com

*Stay up-to-date* on daily news coverage and expert analysis covering consumer purchasing habits and behaviors within the fresh perimeter area and improve your bottom line within these departments.



# ingredients & formulating



## Cocoa butter substitute for baked foods

AAK launched a cocoa butter substitute, Cebes choco 15, a patented compound that allows up to 15% of cocoa ingredients to enhance cocoa flavor in products such as baked foods. Other cocoa butter substitutes on the market may have bloom and sensory qualities if the amount of cocoa ingredients exceeds 5%, according to the company.

“We are very excited to launch Cebes choco 15, the only compound on the market that allows up to 15% of cocoa ingredients,” said Luis Parra, AAK’s global director of chocolate and confectionery fats. “It is an innovative, highly flexible solution that can help brands max out on their product’s taste while maintaining longer-lasting quality and cost-efficient processing.”

Cebes choco 15 supports a long shelf life and avoids bloom even in high-cocoa recipes to ensure products retain a glossy appearance, remain hard and stable at room temperature, and are pleasant to the touch.

(973) 344-1300 • [www.aak.com](http://www.aak.com)

©Alra Vais-stock.adobe.com

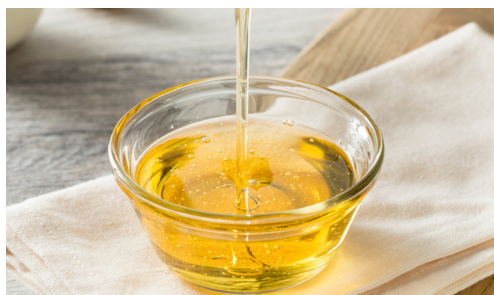


## 100% shea-based cocoa butter equivalent

Karibon from **Bunge Loders Croklaan** is a 100% shea-based cocoa butter equivalent (CBE), which offers a clean label replacement or partial replacement for cocoa butter. In addition to its sustainable profile, shea offers a better nutritional profile than other CBEs with higher levels of stearic acid and lower levels of saturated fat.

(800) 621-4710 • [www.bungeloders.com](http://www.bungeloders.com)

©verkung-stock.adobe.com



## Three reduced-sugar syrups with agave and tapioca

**Ciranda** introduced a line of reduced-sugar syrups. Tapioca syrup RS18 is a clear, mildly viscous syrup produced from tapioca starch using enzymes, while agave syrup AL40 is a sweet, amber-colored syrup produced by hydrolyzing the carbohydrates in the blue agave plant using enzymes. Agave Syrup IN10 is a light amber syrup produced by hydrolyzing the naturally occurring carbohydrates in the blue agave plant.

(715) 386-1737 • [www.ciranda.com](http://www.ciranda.com)

©Brent Hofeder-stock.adobe.com

All images have been supplied by the company unless otherwise stated.



### Reducing acrylamide in biscuits and cookies

PreventASE from DSM helps reduce acrylamide levels in biscuits and cookies by up to 95%. Since the potentially harmful chemical was discovered in 2002, reducing acrylamide levels in baked goods has been a priority for the industry. Now, with new legislation on the horizon, DSM's PreventASE gives bakers an easy and reliable way to reduce acrylamide, even in applications with a low-moisture content like biscuits and cookies, according to the company.

(574) 237-6974 • [www.dsm.com](http://www.dsm.com)



### Organic citrus fiber ingredients

Fiberstar Inc. launched Citri-Fi 400FG and Citri-Fi 400M40, two organic citrus fiber ingredients that provide water-holding and emulsification properties similar to the company's Citri-Fi 100 series. Citri-Fi 400FG and Citri-Fi 400M40 differ by particle size. Potential applications include baked foods, nutrition bars and frozen foods.

[www.fiberstar.net](http://www.fiberstar.net)



### Plant-based orange color for snacks and bakery products

Shade Vivid Orange – OS from GNT is an oil-soluble, plant-based color made from paprika. Part of the company's Exberry portfolio, Shade Vivid Orange – OS is a vibrant orange shade and may replace paprika oleoresin and artificial colors. It can be used in snack seasonings and bakery products.

[www.exberry.com](http://www.exberry.com)



### Sodium aluminum phosphate alternative

Innophos added Levair Select to its Levair baking portfolio. Levair Select, a non-aluminum-based alternative to traditional sodium aluminum phosphate (SALP), provides bakers with a calcium-based product to help create clean label items, according to the company.

(609) 495-2495 • [www.innophos.com](http://www.innophos.com)



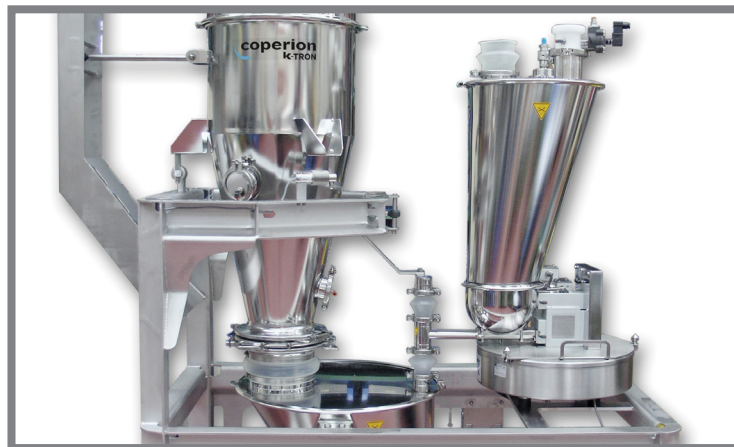
### Natural flavor and shelf life in cakes

J&K Ingredients expanded its realm of clean label ingredients with SOR — Mate Cake. Developed for cakes, it is derived from plants and fruit extracts. SOR — Mate Cake provides natural flavor with a high level of sorbic acid, which makes it an effective replacement for chemical sorbic acid and potassium sorbate. With SOR — Mate Cake, bakers can maintain the shelf life of their cakes while also delivering a cleaner ingredient list.

(973) 340-8700 • [www.jkingredients.com](http://www.jkingredients.com)



# equipment & packaging



## Batch weighing system for improved accuracy

The K-Tron batch weighing system from **Coperion** is designed for accurate batching direct to blenders/mixers. The station features a P100 batch weigh receiver combined with a KT20 loss-in-weight, twin-screw feeder mounted on a collection hopper. The batch weigh receiver combines a vacuum receiver with a reliable weighing system for batching major ingredients. The resulting combination allows ingredients to be conveyed and weighed so that accurate batching of ingredients can take place on a cumulative or sequential basis.

“This system offers our customers the ability to eliminate manual handling and manual weighing,” said Dan Veilleux, Coperion’s industry manager for the baking industry. “It also ensures repeatable, highly accurate weighments to ensure product quality and consistency.”

The KT20 loss-in-weight, twin-screw feeder can be used to accurately add smaller amounts of high-value minor ingredients to the batch. Twin-screw feeders can handle more difficult materials such as vitamins, probiotics or difficult flowing powders such as spices and flavorings. The complete station is constructed of stainless steel and executed in food grade finish.

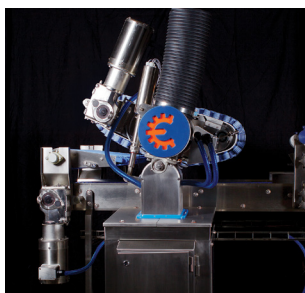
(785) 825-3872 • [www.coperion.com](http://www.coperion.com)



## Loading system for trays, cartons and cases

The Spider 100v loading solution from **BluePrint Automation** replaces traditional collate-and-load systems, eliminating racetrack collation and potential jam points. Increasing line efficiency, the system picks random, unoriented product, eliminating the need to perfectly orient the product prior to entering the packer. The integrated vision system provides built-in product inspection, which can detect double wraps and bad product sizes.

(804) 520-5400 • [www.blueprintautomation.com](http://www.blueprintautomation.com)



## Sanitary depanner line

**Capway Automation**’s Provident Series Depanner represents the next generation in depanning technology. Designed to anticipate future sanitation requirements, it offers ease of cleaning and eliminates areas where microbiological growth may occur. With the depanner, the company said, bakeries can meet higher sanitary standards without sacrificing operational performance.

(877) 222-7929 • [www.capwayautomation.com](http://www.capwayautomation.com)



### Mixer for a range of food applications

**Diosna's** All-Rounder Universal Mixer V100 combines proven mixing technology with a flexible range of applications in the food industry, including sports nutrition. The mixer delivers results with short process times for solid mixtures even with the addition of liquids. The All-Rounder Universal Mixer V100 is available from the smallest scale with an 11.5-liter vessel to large systems with up to 1,400-liter vessels.

(404) 202-1268 • [www.diosna.com](http://www.diosna.com)



### Depositor with 12 dosing cylinders

**GEA's** new Bake Depositor MO volumetric cylinder depositor is designed for depositing muffin, cake and cupcake mixes. The machine's dosing piston is moved by a servo motor, and the dosing cylinder can only be activated after a product has been inserted. With 12 dosing cylinders to control, the system can reduce annual operating costs and significantly cut CO<sub>2</sub> emissions, according to the company.

[www.gea.com](http://www.gea.com)



### Pneumatic conveying control instrumentation

The STP 61 pneumatic conveying control system from **Gericke USA** features 14 different languages to ensure conveyor operation instructions are accurately given to operators via their native tongue. Delivered pre-programmed in English, Spanish, Portuguese, Chinese, Dutch, German, French, Thai and six other languages, the STP 61 conveyor controller invites language selection on the opening screen of the full-color, touchscreen display before advancing to selections for desired throughput rate and bulk density of the conveying material.

(855) 888-0088 • [www.gerickegroup.com](http://www.gerickegroup.com)



### Multi-lane cookie solutions

**Handtmann** offers a wide range of precision single and high-volume cookie solutions for traditional and gluten-free formulations. The company's systems deliver consistent quality, accurate scaling and handle product gently with a short product path that creates less friction so inclusions can retain their highest value.

(847) 808-1100 • [www.handtmann.us](http://www.handtmann.us)



### Compact X-ray inspection system

The X34C compact X-ray inspection system from **Mettler-Toledo** enables foreign object detection in small, individually wrapped snacks at high production speeds. Due to its compact design with a footprint of only 700 mm in length, the X34C can be used in production lines with limited production space. The X34C supports belt speeds of up to 120 meters per minute, which makes it possible to match X-ray inspection to the high speeds of many form/fill/seal machines.

(813) 889-9500 • [www.mt.com/pi](http://www.mt.com/pi)





### Flexible system for industrial production capacity

Rademaker's Radini line is designed for dough capacities between 400 and 1,000 kilograms per hour. The Radini concept is based on an intuitive control interface through PC capabilities. Due to its modular construction, the various components can be reconfigured to form a complete two- or three-section laminator, which creates a variety of layout possibilities with a relatively small footprint.

(330) 650-2345 • [www.rademaker.com](http://www.rademaker.com)



### Pizza dough divider for exact portioning

The Vemag Pizza Dough Divider from Reiser features a double-screw portioning system for accurate scaling with minimal work on the product. For frozen pizza dough producers, the company provides traditional dividing and rounding. On high-speed lines, Reiser has developed methods to portion directly onto trays. For fresh producers, the dividing applications run from a compact Vemag 500 with a cutoff device that produces 60 to 80 portions a minute.

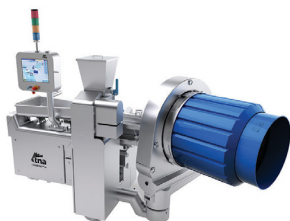
(781) 821-1290 • [www.reiser.com](http://www.reiser.com)



### Sanitary lines for upstream and downstream installations

Rondo's ASTec (Advanced Sanitary Technology) lines are configured for demanding hygiene requirements and are compatible with both upstream and downstream installations. Its design avoids niches and horizontal surfaces, and micro-organisms, dough and product scraps can no longer accumulate. The ASTec line is cleaned according to a computer-based program defined individually for customized production; the cleaning steps are logged for audit.

(201) 229-9700 • [www.rondo-online.com](http://www.rondo-online.com)



### Versatile seasoning system

The Intelli-flav 5.1 from TNA features a responsive variable mass seasoning function with a vibratory weigh conveyor to directly control product, oil spray and flow of seasoning powder into a single drum. As a result, manufacturers benefit from the accurate seasoning of a wide range of hot and cold products on the same system. It also allows for consistent coverage without costly ingredient losses.

(972) 462-6500 • [www.tnasolutions.com](http://www.tnasolutions.com)



### Weigh feeding system

Volkmann introduced its Vibratory Feeder Dosing System. The vibrating feeder automatically weighs precise amounts of powders, pellets, flakes and other bulk materials and gently doses them into hoppers, mixers, baggers and vertical form/fill/seal machines. The vibratory weigh feeder features a proprietary vibrator design that sets the powder or other material in a uniform layer while advancing the material toward discharge in a first-in, first-out process.

(609) 265-0101 • [www.volkmannusa.com](http://www.volkmannusa.com)



## Circular biscuit

This patent is for an ornamental design for a biscuit, as shown and described.

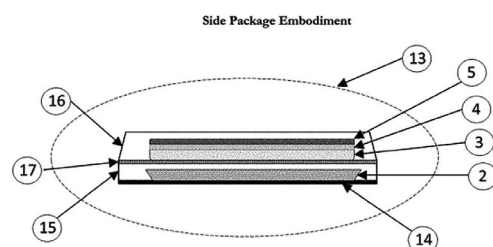
US Patent No. D973,302 (Dec. 27, 2022), J.M. Margrève, assigned to **Lotus Bakeries N.V.**, Lembeke, Belgium.



## Method for pizza preparation

A method for preparing a pizza product in a microwave oven is described and shown in this patent.

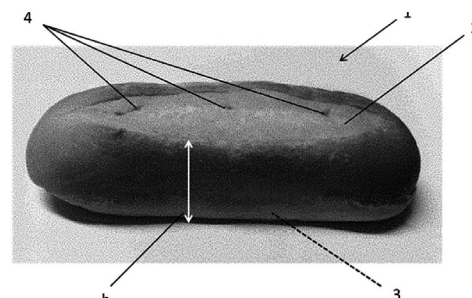
US Patent No. 11,533,918 (Dec. 27, 2022), F.B. Fischmann and V. Santiago, assigned to **YAE LLC**, Coral Gables, Fla.



## Process for a soft bakery product

This patent reveals a process for creating a soft-baked food obtained from a flour-based leavened dough.

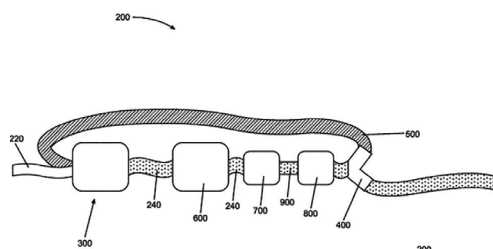
US Patent No. 11,540,521 (Jan. 3, 2023), R. Buttini, et al., assigned to **Barilla G. E R. Fratelli S.p.A.**, Parma, Italy.



## Continuous coating method

A system for making a food composition, which includes an enrober, a dryer, a splitter and a conveyor apparatus, is described in this patent.

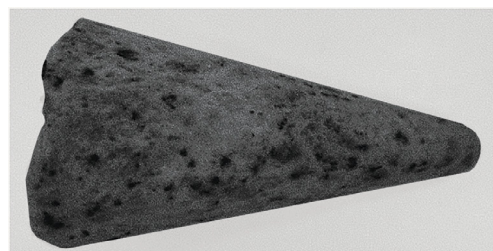
US Patent No. 11,540,552 (Jan. 3, 2023), D.R. Green, et al., assigned to **General Mills Inc.**, Minneapolis.



## Edible ice cream cornet

This patent shows and describes an ornamental design for an edible ice cream cornet.

US Patent No. D974,698 (Jan. 10, 2023), S. Wade and M. Puaud, assigned to **Froneri International Ltd.**, Northallerton, England.



# new on the shelf



## Brioche buns with sesame seeds

**Bakerly**, Coral Gables, Fla., unveiled its brioche burger buns with tuxedo sesame seeds. Free from artificial flavors and colors, the pre-sliced buns come in packs of four and sell for a suggested retail price of \$4.49.

[www.bakerly.com](http://www.bakerly.com)



## Pretzel- and sesame-flavored bagels

Los Angeles-based **BetterBrand** expanded its The Better Bagel portfolio with two new varieties: The Pretzel and The Sesame. The Better Bagel has the net carbohydrate equivalent of two banana slices and the sugar content of one stalk of celery, according to the company. Both The Pretzel and The Sesame contain more than 25 grams of protein per serving.

[www.eatbetter.com](http://www.eatbetter.com)



## Two flavors of crunchy popcorn

Youngstown, Ohio-based **Big Dipper Food Co.** introduced PopCrunch popcorn. Peanut Butter PopCrunch features popcorn smothered in caramel and a peanut butter coating. The Almond Butter variety also features popcorn covered in caramel but with an almond butter coating. Peanut Butter PopCrunch sells for a suggested retail price of \$3.99; Almond Butter PopCrunch goes for \$4.99.

[www.bigdipperfood.com](http://www.bigdipperfood.com)



## Macadamia nut oat bars

**Kate's Real Food**, Jackson, Wyo., debuted gluten-free white chocolate macadamia bars. The oat-based bars are cholesterol free, certified organic and made using Non-GMO Project verified ingredients. There are two servings per full-sized bar; each serving contains 4 grams of protein and 2 grams of fiber.

[www.katesrealfood.com](http://www.katesrealfood.com)



## Chocolate chip cookies with fudge chunks

Parsippany, NJ-based Ferrara added to its **Keebler** lineup with the launch of Chips Deluxe Fudgy, an innovation the company claims is “fudgier than ever, crafted with sweet chocolatey chips and indulgent fudge chunks.” Keebler Chips Deluxe Fudgy sell for a suggested retail price of \$4.80 for a 9.6-oz package.

[www.keebler.com](http://www.keebler.com)



### Gluten-free strawberries and creme bars

Los Angeles-based **Lenny & Larry's** added a Strawberries and Creme flavor to its The Complete Cookie-fied Bar portfolio. Available in boxes of four, the bars are gluten-free and made using Non-GMO Project verified ingredients. Each soft-baked bar contains 12 grams of plant protein and 5 grams of prebiotic fiber per serving.

[www.lennylarry.com](http://www.lennylarry.com)



### Crushed pretzel bit toppings

**Pretzel Pete Inc.**, Hatboro, Pa., introduced Topzels, flavored pretzel bits produced by grinding and sifting normal sized pretzels, resulting in a fine, crumb-like product that is then seasoned in various flavors. Available in two varieties — Salted Caramel and Cinnamon Brown Sugar — Topzels are available in 6-oz resealable bags for retail as well as 2-lb bags for food service applications.

[www.pretzelpete.com](http://www.pretzelpete.com)



### Upcycled English muffins

**Stone & Skillet LLC**, Boston, and Berkeley, Calif.-based **Upcycled Foods Inc.** launched Super Grains English Muffins, which contain 6 grams of fiber and 6 grams of protein per serving. Available in a four-count, 12-oz bakery pack, the Super Grains English Muffins sell for a suggested retail price of \$5.99.

[www.upcycledfoods.com](http://www.upcycledfoods.com)



### Dessert-flavored protein bars

Los Angeles-based **think!** introduced two dessert-inspired flavors to its line of protein bars. The brand's Boston Creme Pie flavor delivers 15 grams of protein, 4 grams of fiber and 1 gram of sugar; the Chocolate Mint variety contains 20 grams of protein, two grams of fiber with zero grams of sugar. Both flavors are available in a five-count box for \$9.99; single bars sell for a suggested retail price of \$2.29.

[www.thinkproducts.com](http://www.thinkproducts.com)



### Gluten-free chocolate chip cookie dough

**Whoa Dough**, Highland Heights, Ohio, introduced Chocolate Chip Cookie Dough. The sweet and salty refrigerated snack can be eaten straight from the package or baked into nine chocolate chip cookies within minutes. Gluten-free, vegan, egg-free, nut-free, soy-free and dairy-free, Whoa Dough Chocolate Chip Cookie Dough contains 90 calories and 8 grams of sugar per serving.

[www.whoadough.com](http://www.whoadough.com)



INGREDIENTS

WE BUY  
CANDY, FOOD & BEVERAGE

**CLOSEOUTS**



Nationwide pick up since 1993

Call Jon (954) 649-7857

e-mail: [jon@whamfoods.com](mailto:jon@whamfoods.com)  
web [www.whamcloseoutfoods.com](http://www.whamcloseoutfoods.com)



**Your #1 Ingredient Supplier**

Custom Mixes - Flour - Sugar - Grains  
Fats & Oils - Dried Fruit & Nuts - Eggs

[www.capitolfoodco.com](http://www.capitolfoodco.com)  
E-mail: [info@capitolfoodco.com](mailto:info@capitolfoodco.com)  
Phone: 562-404-4321 • Fax: 562-404-1041




EQUIPMENT



Clean, strong, long-lasting plastic proofing boards  
in the sizes you need.

Ask us about our  
“non-stick” pattern

800\*411\*4086 [www.esterle.com/tuf-tray](http://www.esterle.com/tuf-tray) Manufactured by  ESTERLE

All Major Credit  
Cards Accepted

**FREE  
IN-PLANT TRIAL  
MIXERS &  
BLENDERS**



New & refurbished  
with genuine  
OEM warranty.

Try our mobile app:  
[mixers.com/web-app](http://mixers.com/web-app)

**1-800-243-ROSS**  
[www.Rental-Mixers.com](http://www.Rental-Mixers.com)




Campbell Systems, Inc.

**Is Your OSHA mandated  
DHA on file and current?**

- ◆ Bread, Bun, & Sheetting Lines
- ◆ Hood and Duct Upgrades
- ◆ Ingredient Scaling Containment
- ◆ FSMA & NFPA Benefits

Bakery Dust Collection Systems  
[campbellsystemsinc.com](http://campbellsystemsinc.com)  
**770.641.5075**



SAVE  
MORE  
FLOUR  
MAKE  
MORE  
DOUGH

**BAKERY PAN &  
BASKET WASHERS**



KUHL CORP. - FLEMINGTON, NJ 08822 - USA  
[hyk@kuhlcorp.com](mailto:hyk@kuhlcorp.com)

**The most important  
FOOD SAFETY  
STORIES**

**delivered to your inbox.**

**Food Safety Monitor**

A biweekly e-newsletter published  
by Sosland Publishing's staff of  
industry leading editors

Sign up at  
[www.bakingbusiness.com](http://www.bakingbusiness.com)

**For Classified Advertising  
In Baking&Snack,**

Contact: Lauren Juliana, 816-835-8235 • [ljuliana@Sosland.com](mailto:ljuliana@Sosland.com)  
or go directly to our website to include your classified ad online  
<https://www.bakingbusiness.com/classifieds>



## EQUIPMENT



## CURRENT INVENTORY

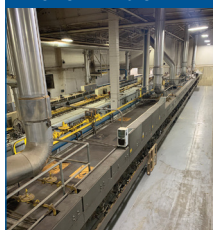
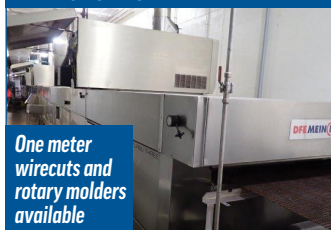
CALL: Office 406-252-3521

WEB: [WWW.BAKERYEQUIPMENTANDCONTROLS.COM](http://WWW.BAKERYEQUIPMENTANDCONTROLS.COM)EMAIL: [MEGAN@BEC-MT.COM](mailto:MEGAN@BEC-MT.COM) or [PATTY@BEC-MT.COM](mailto:PATTY@BEC-MT.COM)**BOSCH TRAY LOADER**  
2 Available**HASS-MEINCKE**  
1.2 METER, 4 ROLL  
SHEETER**1.2 METER APV ANGLE**  
WIRECUT**1.2 METER APV WORLD**  
WIRECUT**1.2 METER IMAFORNI LAMINATED CRACKER OR COOKIE LINE**

INCLUDES: Pre-sheeter, Laminator, Laminator Incline Conveyor to Four Sheeting Rolls in Excellent Condition

**1.2 METER  
T.L. GREEN  
CRACKER  
MACHINING LINE  
AND HYBRID  
OVEN**New  
Inventory!**BAKER PERKINS**  
TWO ZONE OVEN

60 Inch Wide Band w/ World Wirecut

**SASIB, 280' X 1.2 METER**  
6 ZONE DFG OVEN**MEINCKE 150' X 1 METER**  
5 ZONE OVEN AVAILABLEOne meter  
wirecuts and  
rotary molders  
available

## CREATING CUSTOM SOLUTIONS SINCE 1972

[www.geminibakeryequipment.com](http://www.geminibakeryequipment.com) • 215.673.3520

#WeDoughItAll

## Rack and Deck Ovens to meet your Baker's Needs

## D Series Deck Ovens

- Electric Deck Ovens
- 4-16 pan capacity



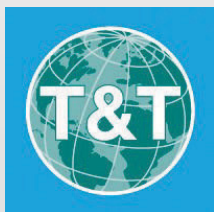
SVEBA-DAHLEN

## Rack Ovens

- Electric or gas fired rack ovens
- 10-80 pan capacity



Knowledge ✨ Passion ✨ Legendary Customer Service



**T&T Consulting and Engineering, Inc.**

***“THE WORLD IS OUR SHOP”***

**www.TandTCE.com**



In addition to remanufactured equipment,

T&T is now offering all new equipment from its facility in Illinois.

- Large capacity Pizza Dough Proofers.
- Direct fired and Indirect fired Tunnel ovens up to 13 ft wide.
- Thermal Oil type multi deck tunnel ovens.
- Impingement type Pizza Crust tunnel ovens.
- Conveyor systems.
- Oven loaders and unloaders.
- Auto tray and step proofers.
- All new conveyor systems.



**T&T Consulting & Engineering, Inc.**

Tel: 1.847.288.9809

Fax: 1.847.288.9709

Contact@TandTCE.com

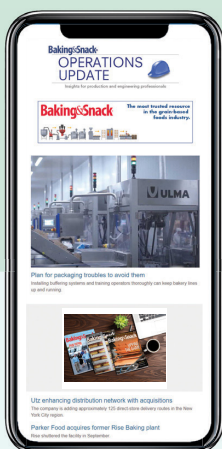
www.TandTCE.com

**Experienced in Winkler and Gemini tunnel oven upgrades**

**Baking & Snack**



# A PRECISION OPERATION



**Get the comprehensive, targeted information you need to improve your business operations.**

*Baking & Snack's Operations Update* newsletter provides the latest news and information on engineering, production, packaging, maintenance and sanitation.



**Subscribe to the free  
Operations Update newsletter**

**SIGN UP AT**

[bakingbusiness.com/newsletter\\_subscriptions](http://bakingbusiness.com/newsletter_subscriptions)





The following advertisers appear in this issue and most maintain sites on the World Wide Web. As we learn of additional advertiser websites, they will be listed in coming issues. The publisher welcomes information that updates this list.

Page No.	Page No.	Page No.
<b>Allied Blending LP</b> .....59	<b>Grain Craft</b> .....115	<b>Peerless Food Equipment</b> .....60
<a href="http://www.alliedblending.com">www.alliedblending.com</a>	<a href="http://www.graincraft.com">www.graincraft.com</a>	<a href="http://www.peerlessfood.com">www.peerlessfood.com</a>
<b>American Bakers Association</b> .....53, 85	<b>Great Western Manufacturing Co., Inc.</b> .....26	<b>The Fred D. Pfening Co.</b> .....25
<a href="http://www.americanbakers.org">www.americanbakers.org</a>	<a href="http://www.gwmfg.com">www.gwmfg.com</a>	<a href="http://www.pfening.com">www.pfening.com</a>
<b>American Dairy Product Institute</b> .....96	<b>Handtmann Inc.</b> .....9	<b>Promach</b> .....91
<a href="http://www.adpi.org">www.adpi.org</a>	<a href="http://www.handtmann.us">www.handtmann.us</a>	<a href="http://www.promachbuilt.com">www.promachbuilt.com</a>
<b>American Key Food Products</b> .....48	<a href="http://www.handtmann.ca">www.handtmann.ca</a>	<b>Quantum Technical Seives Inc</b> .....33
<a href="http://www.akfponline.com">www.akfponline.com</a>	<b>Heat and Control, Inc.</b> .....71	<a href="http://www.q-t-s.com">www.q-t-s.com</a>
<b>AMF Bakery Systems</b> .....79, 116	<a href="http://www.heatandcontrol.com">www.heatandcontrol.com</a>	<b>Rademaker USA, Inc.</b> .....24
<a href="http://www.amfbakery.com">www.amfbakery.com</a>	<b>IMA Ilapak</b> .....70	<a href="http://www.rademaker.com">www.rademaker.com</a>
<b>Axiflow Technologies, Inc.</b> .....30	<a href="http://www.ima.it">www.ima.it</a>	<b>The Radio Frequency Co., Inc.</b> .....76
<a href="http://www.axiflowtechnologies.com">www.axiflowtechnologies.com</a>	<b>International Food Products Corp.</b> .....46	<a href="http://www.radiofrequency.com">www.radiofrequency.com</a>
<b>BABBCO (C.H. Babb Co., Inc.)</b> .....83	<a href="http://www.ifpc.com">www.ifpc.com</a>	<b>Reading Bakery Systems</b> .....63
<a href="http://www.babbco.com">www.babbco.com</a>	<b>Intralox, LLC</b> .....37	<a href="http://www.readingbakery.com">www.readingbakery.com</a>
<b>Baxter Manufacturing</b> .....81	<a href="http://www.intralox.com">www.intralox.com</a>	<b>Reiser</b> .....31
<a href="http://www.baxtermfg.com">www.baxtermfg.com</a>	<b>IPCO</b> .....80	<a href="http://www.reiser.com">www.reiser.com</a>
<b>Brolite Products, Inc.</b> .....39	<a href="http://www.ipco.com">www.ipco.com</a>	<b>Risco USA</b> .....73
<a href="http://www.bakewithbrolite.com">www.bakewithbrolite.com</a>	<b>JLS Automation</b> .....82	<a href="http://www.riscousa.com">www.riscousa.com</a>
<b>Bundy Baking Solutions</b> .....27	<a href="http://www.jlsaautomation.com/talon">www.jlsaautomation.com/talon</a>	<b>ROSS Mixers</b> .....17
<a href="http://www.bundybakingsolutions.com">www.bundybakingsolutions.com</a>	<b>Kerry</b> .....47	<a href="http://www.mixers.com">www.mixers.com</a>
<b>Cain Food Industries, Inc.</b> .....43	<a href="http://www.kerry.com">www.kerry.com</a>	<b>Schubert North America</b> .....93
<a href="http://www.cainfood.com">www.cainfood.com</a>	<b>KettenWulf</b> .....74	<a href="http://www.schubertgroup.com">www.schubertgroup.com</a>
<b>Capway Automation</b> .....68-69	<a href="http://www.kettenwulf.com">www.kettenwulf.com</a>	<b>Shick Esteve</b> .....11
<a href="http://www.capwayautomation.com">www.capwayautomation.com</a>	<b>Lubriplate Lubricants</b> .....2	<a href="http://www.shickesteve.com">www.shickesteve.com</a>
<b>Cavanna Packaging USA, Inc.</b> .....32	<a href="http://www.lubriplate.com">www.lubriplate.com</a>	<b>St. Johns Packaging</b> .....95
<a href="http://www.cavanna.com">www.cavanna.com</a>	<b>Manildra Group USA</b> .....36	<a href="http://www.sjpack.com">www.sjpack.com</a>
<b>CII Foods</b> .....50	<a href="http://www.manildrausa.com">www.manildrausa.com</a>	<b>Syntegon</b> .....89
<a href="http://www.ciifoods.com">www.ciifoods.com</a>	<b>Mecatherm S.A.</b> .....77	<a href="http://www.syntegon.com">www.syntegon.com</a>
<b>Columbus Vegetable Oils</b> .....58	<a href="http://www.mecatherm.fr">www.mecatherm.fr</a>	<b>Tecnopool SPA</b> .....18
<a href="http://www.columbusvegloils.com">www.columbusvegloils.com</a>	<b>The Mennel Milling Co.</b> .....54	<a href="http://www.tecnopool.it">www.tecnopool.it</a>
<b>DakotaMB</b> .....57	<a href="http://www.mennel.com">www.mennel.com</a>	<b>Van Der Graaf</b> .....False Cover, 67
<a href="http://www.dakotamb.com">www.dakotamb.com</a>	<b>Middleby Bakery</b> .....21	<a href="http://www.vandergraaf.com">www.vandergraaf.com</a>
<b>Eriez</b> .....35	<a href="http://www.middprocess.com">www.middprocess.com</a>	<b>Vantage Food</b> .....34, 49
<a href="http://www.eriez.com">www.eriez.com</a>	<b>Multivac (Fritsch/Baking)</b> .....65	<a href="http://www.vantagegrp.com">www.vantagegrp.com</a>
<b>Eurogerm KB LLC</b> .....55	<a href="http://www.fritsch-group.com">www.fritsch-group.com</a>	<b>Volkman Inc.</b> .....19
<a href="http://www.eurogerm-kb.com">www.eurogerm-kb.com</a>	<b>North Dakota Mill</b> .....44, 45	<a href="http://www.volkmannusa.com">www.volkmannusa.com</a>
<b>Formost Fuji Corp.</b> .....6	<a href="http://www.ndmill.com">www.ndmill.com</a>	<b>Weber</b> .....4
<a href="http://www.formostfuji.com">www.formostfuji.com</a>	<b>Pack Expo</b> .....86	<a href="http://us.weberweb.com">us.weberweb.com</a>
<b>Fortress Technology, Inc.</b> .....72	<a href="http://www.packexpolasvegas.com">www.packexpolasvegas.com</a>	<b>Wire Belt Co.</b> .....23
<a href="http://www.fortresstechnology.com">www.fortresstechnology.com</a>	<b>Paxiom</b> .....3	<a href="http://www.wirebelt.com">www.wirebelt.com</a>
<b>Gemini Bakery Equipment Co./KB Systems, Inc.</b> .....38	<a href="http://www.paxiom.com">www.paxiom.com</a>	
<a href="http://www.geminibakery.com">www.geminibakery.com</a>		
<a href="http://www.kbsystemsinc.com">www.kbsystemsinc.com</a>		

This index is provided as an additional service to readers. The publisher does not assume any liability for errors or omissions.

BAKING & SNACK (ISSN 1092-0447) Volume 45, issue 7 is published monthly except in January by Sosland Publishing Company, 4801 Main Street, Suite 650, Kansas City, MO 64112. Periodicals postage paid at Kansas City, MO 64108 and additional mailing offices. Printed in the USA. POSTMASTER: Send address changes to BAKING & SNACK, PO Box 3001, Northbrook

IL 60065-9743. ©2023 Sosland Publishing Company. All rights reserved. Reproduction of the whole or any part of the contents without written permission is prohibited. BAKING & SNACK assumes no responsibility for the validity of claims in items reported. Sosland Publishing Company is a division of Sosland Companies, Inc.



4801 Main St., Suite 650  
Kansas City, Mo. 64112  
Phone: (816) 756-1000  
E-mail: bakingsnack@sosland.com

**Baking & Snack** Food Business News **MEAT+POULTRY** **WORLD GRAIN** **bake**  
**Milling & Baking News** **PERIMETER** **DAIRY PROCESSING** **Food Entrepreneur**  
 Sosland Publishing **TRENDS AND INNOVATIONS** **Food Entrepreneur Experience**  
 A SCSLAND PUBLISHING SEMINAR

## NEW PRODUCT SPOTLIGHT



# HIGH AND MIGHTY

Mightylicious enters the soft-baked gluten-free cookie category.

Mightylicious' gluten-free cookies are available in seven flavors.

Mightylicious

Carolyn Haeler had a problem. She couldn't find a gluten-free cookie that didn't crumble in her hands after taking a bite. So she did what any sensible, cookie-loving entrepreneur would do — she created her own. Mightylicious soft-baked gluten-free cookies were born.

"I realized there had to be a better way," said Ms. Haeler, founder of the Woodbridge, NJ-based company. "I was determined to create a cookie that was gluten-free, healthy and, above all, irresistibly delicious."

The idea for Mightylicious cookies was also influenced by Ms. Haeler's celiac disease diagnosis.

"I was diagnosed in 2012," she explained. "Back then there were very few gluten-free options. Over the years, more gluten-free brands hit the shelves, but while there were more options to choose from, there wasn't an increase in quality. One day in 2017, I purchased a bag of gluten-free cookies that I threw away before I even left the store. That was the moment that I decided to start my company. I left my job and started testing recipes in my apartment. When I had something that I was proud of, I took it to Whole Foods to get feedback. They loved it, and I was onboarded to their regional supplier program that week. The rest is history."

As a point of differentiation to other gluten-free and allergen-free baked goods, Mightylicious prioritizes taste.

"Our cookies taste good," Ms. Haeler said. "People buy food because it tastes good. I don't care how healthy

a food is, if it doesn't taste good, people won't buy it. In most products that are marketed as better-for-you and allergy friendly, there is a strong emphasis on quality of life and health but a formidable lack in the basic need for enjoyable satiation. We take the opposing angle: Our focus is on indulgence and the enjoyment of food. We just happen to be better-for-you."

The company's motto — "Life's complicated; cookies shouldn't be" — highlights Mightylicious' rather simple goal: Make healthy, great-tasting, gluten-free cookies available to a wide range of customers.

"We have offerings for many lifestyles and allergies, including gluten, egg, dairy and soy intolerance," Ms. Haeler explained. "However, our cookies are for anyone who eats cookies, which I assume is almost everyone, and wants a great-tasting snack that is also better-for-you. I think that this segment encompasses most people, such as millennials, Generation Z and baby boomers."

Available in seven varieties — Brown Butter Chocolate Chip, Brown Butter Shortbread, Oatmeal Raisin, Double Dutch Chocolate Chip, Salted Peanut Butter, Vegan Chocolate Chip and Grandma Arline's Oatmeal Coconut (vegan) — a bag of 10 Mightylicious cookies sells for a suggested retail price of \$7.99. The snack can be purchased at retailers such as Whole Foods, Hy-Vee, Giant, Stop & Shop, Busch's, Price Chopper and Walmart or online at [www.mightylicious.com](http://www.mightylicious.com).

— Keith Moore



# EACH STEP OF THE WAY

As your dedicated partner, we're committed to delivering quality flour and dependable service while building a path of success for you, our industry and our growers.

Check out the **NEW**  
**graincraft.com!**

Don't miss the video library along with formulas, tips and tricks from our flour experts who think about dough all day.

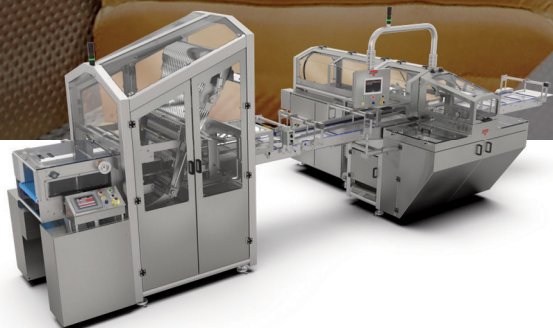


September 11–13, 2023  
Las Vegas Convention Center  
Las Vegas, Nevada USA

**BOOTH #SL-6380**

# SLICED AND BAGGED PERFECTION WITH

## PACKTECH



**BAKERY** SYSTEMS

A Markel Food Group Company



Scan to learn more

## ***SANITARY SLICING AND PACKAGING FOR SOFT BREAD, BUNS, AND MORE***

For high-speed, reliable packaging solutions, AMF PackTech delivers sanitary solutions for bun, roll, and bread slicing and bagging, and bulk bun packaging. The recipe-driven Saber 75S Slicer and Mark 75S Bagger improve the packaging process by introducing a series of automated adjustments that eliminate operator intervention, improve product consistency, and ensure operator safety. Plus, the new design offers easy access for simple, safe sanitation and maintenance. All PackTech equipment is engineered with reliability in mind for simple operation to ensure optimal package quality and extended product shelf life.

**AMFBAKERY.COM | SALES@AMFBAKERY.COM**

© 2023 AMF Bakery Systems

**USA | Netherlands | UK | China | Singapore | Canada | Mexico**